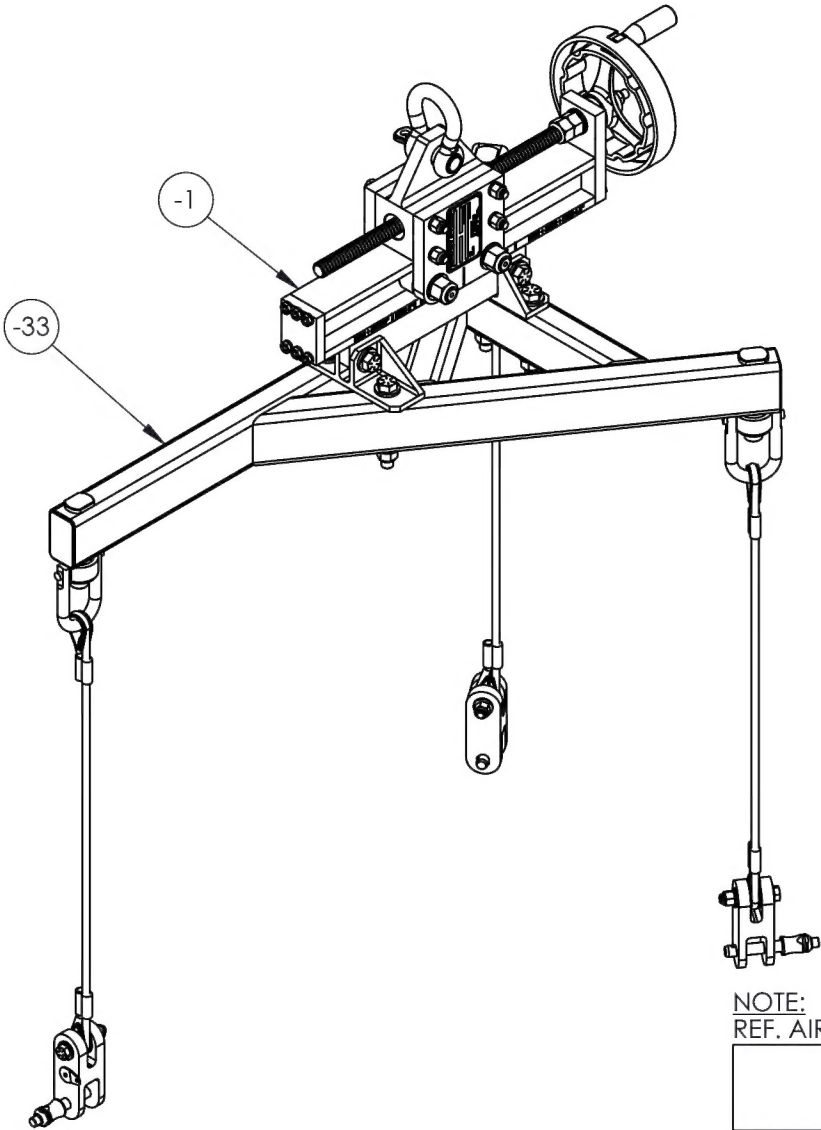


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ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
								X		-1	1	SLING ASSEMBLY			2
							X	1		-3		BEAM WELDMENT			3
							1			-5		BEAM	1018/1020 CR		4
							1			-7		BEAM MOUNT BAR	1018/1020 CR		5
					X			1		-9		SLING BLOCK/CRANK ASSY			6
				X	1					-11		SLING BLOCK ASSEMBLY			7
				1						-13		SLING BLOCK	1018/1020 CR		8
				2						-15		SIDE PLATE	1018/1020 CR		9
				1						-17		ACME SLEEVE NUT	BRONZE	5/8-8 (ROTON #89407) MODIFIED	10
						1				-19		END PLATE	A36/1018/1020 HR		11
				X		1				-21		CRANK END PLATE ASSEMBLY			12
				1						-23		CRANK END PLATE	A36/1018/1020 HR		13
			X			1				-25		ACME ROD ASSEMBLY			14
			1							-27		ACME ROD	STEEL	5/8-8 X 14-3/4 (MCMaster-CARR #93410A620) MODIFIED	15
			1							-29		ACME ATTACHMENT	4140/4142		16
						1				-31		HANDWHEEL	PLASTIC W/ STEEL HUB	[CARRLANE #CL-62-HWAS-P) MODIFIED	17
		X								-33	1	FRAME ASSEMBLY			18
	X	1								-35		FRAME WELDMENT			19
	1									-37		TUBE A	A500		20
	1									-39		TUBE B	A500		21
	1									-41		TUBE C	A500		22
	1									-43		TUBE D	A500		23
		3								-45		BUSHING	1018/1020 CR		24
		1								-47		SMALL MOUNT BRACKET	A36/1018/1020 HR		25
		1								-49		LONG MOUNT BRACKET	A36/1018/1020 HR		26
X		3								-51		CABLE ASSEMBLY			27
1									B/O	-53		CABLE	STEEL	Ø5/16 X 30 (MCMaster-CARR #3440T57)	27
2									B/O	-55		LIFTING THIMBLE	STEEL	13/16 X 1-1/2, Ø5/16 ROPE (MCMaster-CARR #3494T14)	27
2									B/O	-57		COMPRESSION SLEEVE	COPPER	Ø5/16 ROPE (MCMaster-CARR #3898T19)	27
1									B/O	-59		HOIST RING	STEEL	12-13 X 1-1/16 X 4-7/8 (MCMaster-CARR #3145T23)	27
		3								-61		LINK	4140/4142		16
				4					B/O	-63		HEX HEAD CAP SCREW	STEEL GRD 8	3/8-24 X 4-1/4 (MCMaster-CARR #91257A141)	26
				8	1				B/O	-65		FLAT WASHER	STEEL	Ø3/8 (MCMaster-CARR #95229A490)	25
				4	1				B/O	-67		NYLON-INSERT LOCKNUT	STEEL	3/8-24 (MCMaster-CARR #97135A235)	27
				8					B/O	-69		POINT SET SCREW	STEEL	1/4-28 X 1/4 (MCMaster-CARR #92695A311)	7
				4					B/O	-71		TRACK ROLLER	STEEL	5/8-18 X 3/4 X 1-1/2 STUD X Ø1-1/2 X 7/8 (MCMaster-CARR #3652K23)	7
				4					B/O	-73		FLAT WASHER	STEEL	Ø5/8 (MCMaster-CARR #95229A610)	7
				4					B/O	-75		NYLON-INSERT LOCKNUT	STEEL	5/8-18 (MCMaster-CARR #97135A275)	7
			1						B/O	-77		NEEDLE ROLLER BEARING	STEEL	Ø5/8 I.D. X Ø13/16 O.D. X 5/8 (MCMaster-CARR #5905K25)	12
								12	B/O	-81		HEX HEAD CAP SCREW	STEEL	1/4-28 X 1 (MCMaster-CARR #92620A564)	2
								12	B/O	-83		FLAT WASHER	STEEL	Ø1/4 (MCMaster-CARR #95229A430)	2
						2			B/O	-85		THRUST NEEDLE BEARING	STEEL	Ø5/8 I.D. X Ø1-1/8 O.D. X 5/64 (MCMaster-CARR #5909K32)	2
						4			B/O	-87		THRUST BEARING WASHER	STEEL	Ø5/8 I.D. X Ø1-1/8 O.D. X .032 (MCMaster-CARR #5909K45)	2
						2			B/O	-89		ACME NUT	S.S.	5/8-8 ACME THREAD (MCMaster-CARR #95066A213)	2
						1			B/O	-91		SQUARE KEY	STEEL	1/8 X 1 (MCMaster-CARR #98870A110)	2
		3							B/O	-93		QUICK RELEASE PIN	S.S.	ØM12 X 50mm USABLE (MCMaster-CARR #93871A880)	18
		3							B/O	-95		HEX HEAD CAP SCREW	STEEL	3/8-16 X 2-1/4 (MCMaster-CARR #91257A633)	18
		6							B/O	-97		FLAT WASHER	STEEL	Ø3/8 (MCMaster-CARR #98023A031)	18
		3							B/O	-99		NYLON INSERT LOCKNUT	STEEL	3/8-16 (MCMaster-CARR #97135A230)	18
		4							B/O	-101		HEX HEAD CAP SCREW	STEEL	1/2-13 X 4 (MCMaster-CARR #91257A728)	18
		2							B/O	-103		HEX HEAD CAP SCREW	STEEL	1/2-13 X 2-1/4 (MCMaster-CARR #91257A721)	18
		12							B/O	-105		FLAT WASHER	STEEL	Ø1/2 (MCMaster-CARR #98023A033)	18
		6							B/O	-107		NYLON-INSERT LOCKNUT	STEEL	1/2-13 (MCMaster-CARR #97135A250)	18
		3								-109		TUBE CAP	A36/1018/1020 HR		29
		3							B/O	-115		CABLE TAB	ALUMINUM	[CARR LANE CL-129-TAB-A]	18
		3						4	B/O	-117		#2 DRIVE SCREW	STEEL	#2 X 1/4 (MCMaster-CARR #90081A077)	18
		3							B/O	-119		LANYARD	COATED STEEL	Ø1/16 X 10 (CARR LANE #CL-2-C)	N/S
		6							B/O	-121		FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	N/S
								1	B/O	-123		SCREW PIN SHACKLE	S.S.	Ø3/4 PIN 2 TON (MCMaster-CARR #3583T16)	2
		1							B/O	-125		DECAL	BLACK VINYL	[SIGNS NOW]	30
								1	B/O			DART PLACARD	ALUMINUM	RB41011	2
ASSY -51	ASSY -35	ASSY -33	ASSY -25	ASSY -21	ASSY -11	ASSY -9	ASSY -3	ASSY -1							

REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION			8/4/2016	SM	JAG
2	16-0221	<p>-1 ADDED -123 QTY 1 & -117 QTY 4 TO ASSEMBLY. DELETED -65, -67, -85, -87, -89, -91, -111, -113 FROM ASSEMBLY. -3 CH'D NOTE FROM FILL W/ BLACK INK TO FILL W/ RED PAINT. -9 ADDED -65, -67, -85, -87, -89, -91 TO ASSEMBLY. -13 CH'D DIMS FROM Ø.755 THRU ALL ∠ Ø.80 X 90°, BOTH SIDES TO Ø.875 THRU ALL ∠ Ø.98 X 90° BOTH SIDES, FROM Ø1.126-1.129 THRU ALL ∠ Ø1.18 X 90°. BOTH SIDES TO Ø1.125-1.129 THRU ALL ∠ Ø1.18 X 90°. BOTH SIDES. -9 ADDED -65, -67, -85, -87, -89, -91 ADDED TO ASSEMBLY. -15 CH'D DIM WAS 3.525 IS 2X 3.525. ADDED DIMS 2X .91, 2X 1.704, 2X .28, 2X 2.954, 4X Ø.086 ∇ .31, .97, 2.360. DELETED DIM 2.323. -19 ADDED DIM 2X .610. CH'D MAT'L FROM 1018/1020 CR TO A36/1018/1020 HR. -23 CH'D MAT'L FROM 1018/1020 CR TO A36/1018/1020 HR. -25 DELETED -79 FROM ASSEMBLY. ADDED WELD SYMBOL. ADDED FINISH ZINC PLATE ASTM B633 TYPE I SC2. -27 DELETED DIMS .365, Ø.1869-.1874 THRU ALL (P.F. -.79). CH'D FINISH FROM ZINC PLATE ASTM B633 TYPE I SC2 TO SEE -25. -29 DELETED DIMS .375, Ø.1890-.1902 THRU ALL (S.F. -.79). ADDED DIM .10 X 45°. CH'D MAT'L FROM 4140 Q&T/4142 Q&T TO 4140/4142. CH'D FINISH WAS ZINC PLATE ASTM B633 TYPE I SC2 IS SEE -25. -33 CORRECTED ORIENTATION OF -35. ADDED -125 DECAL TO ASSY. -35 ADDED WELD SYMBOLS. CH'D DIM WAS 2.675 IS [2.675]. ADDED -109 TO ASSY. -37, -39, -41, -43 CH'D MAT'L WAS A36/1018/1020 HR IS A500. -61 CH'D MAT'L WAS 1018/1020 CR IS 4140/4142. ADDED DIM 1.47±.05. CH'D DIMS WAS .508 IS .51, WAS Ø.095-.098 ∇ .15 IS Ø.086 ∇ .31. -79 DELETED FROM BOM. -109 ADDED DRAWING. CH'D MAT'L WAS POLYETHYLENE IS A36/1018/1020 HR. WAS B/O IS MANUFACTURED. -111 & -113 DELETED FROM BOM. -117 CH'D B/O REF FROM #2 X 1/8 (#90081A074) TO #2 X 1/4 (#90081A077). -123 ADDED TO BOM QTY: 1. -125 ADDED TO BOM QTY: 1. ADDED DRAWING.</p>			11/15/2016	DPD	JAG

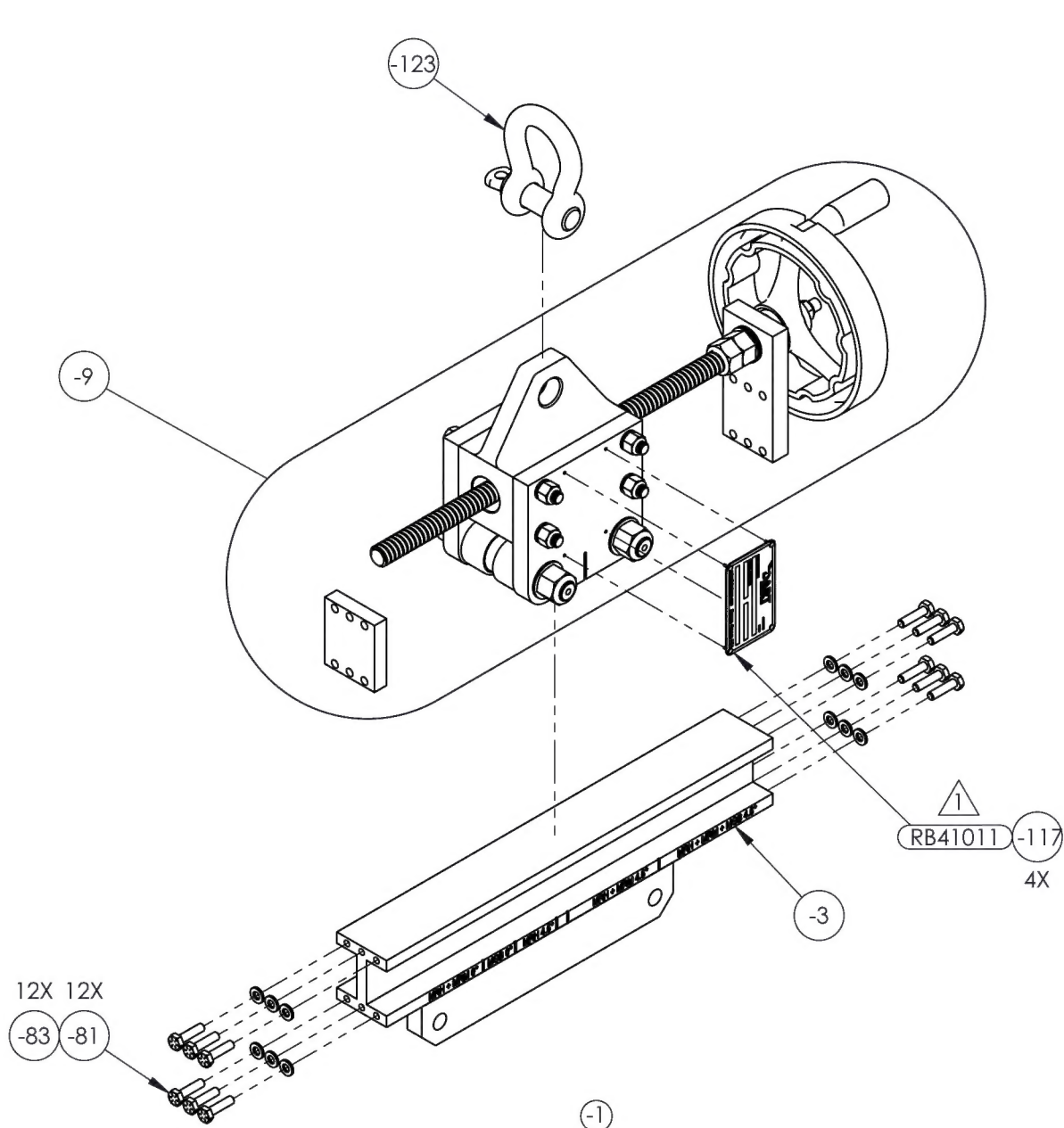


NOTE:
REF. AIRBUS T/N M622U1005130.

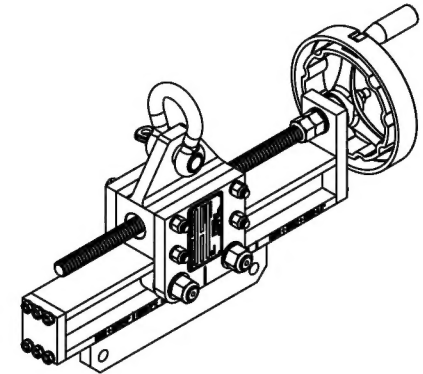
DART AEROSPACE			
TITLE MAIN ROTOR HEAD SLING			
DWG NO. RBEM622U1005103			REV 2
MAT'L HEAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/8 XXX ± .005 .XX ± .01 .X ± .1 ANGLES ±.5° SURFACES = 125/✓	
DRAWN BY: CHECKED: OPPS APPR: QA APPR:		CLOUGH MACKOVJAK ANDERSON LINDSAY	
APPROVED: SCALE		GILBERT 1:8	
DATE		5/13/2016	
SHEET 1 OF 31		H175	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-1 ADDED -123 QTY 1 & -117 QTY 4 TO ASSEMBLY. DELETED -65, -67, -85, -87, -89, -91, -111, -113 FROM ASSEMBLY.	11/15/2016	DPD	JAG



SLING ASSEMBLY



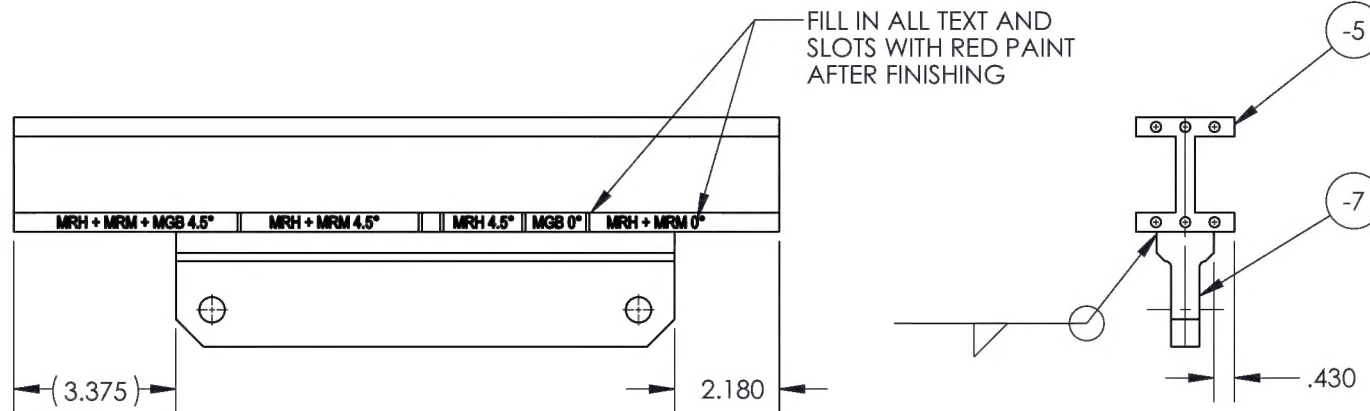
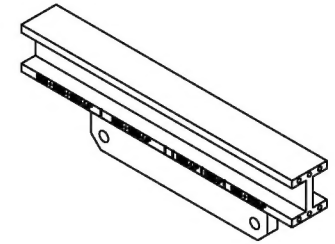
NOTE:

- 1 ENGRAVE PLACARD (RB41011) WITH T/N, S/N, "MADE IN USA" AND "SAFE WORKING LOAD 2039 LBS/925 KG".

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-1	REV 2
MAT'L _____ HEAT _____ TREAT _____ FINISH _____ SPEC _____ UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: MACKOVJAK	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:5	DATE 5/13/2016
SHEET 2 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-3 CH'D NOTE FROM FILL W/ BLACK INK TO FILL W/ RED PAINT.	11/15/2016	DPD	JAG

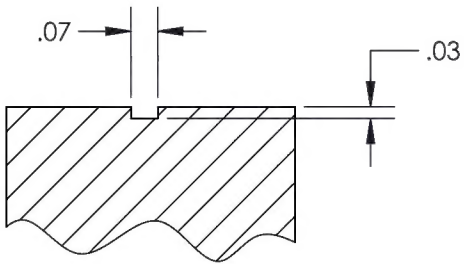


(-3)
BEAM WELDMENT

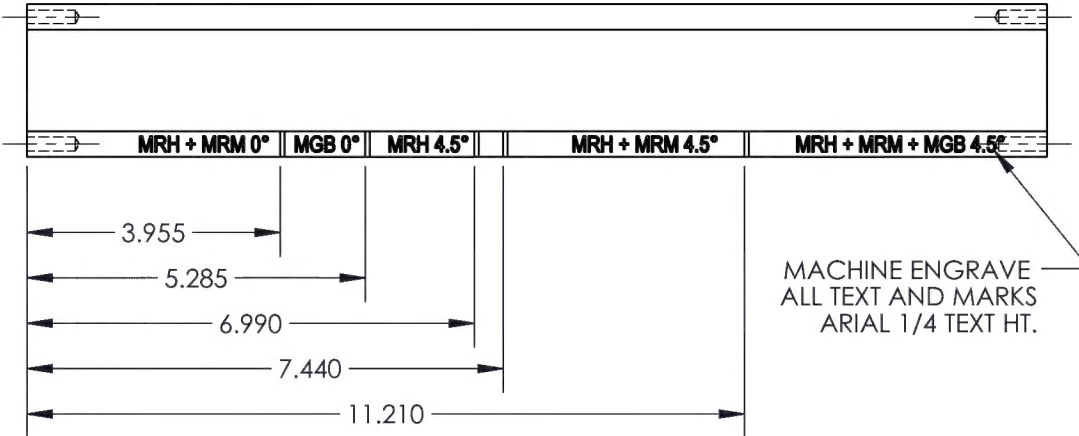
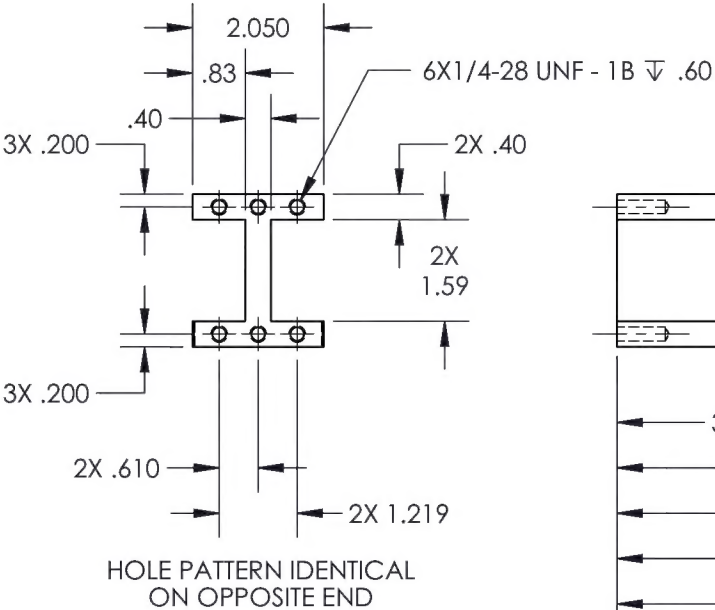
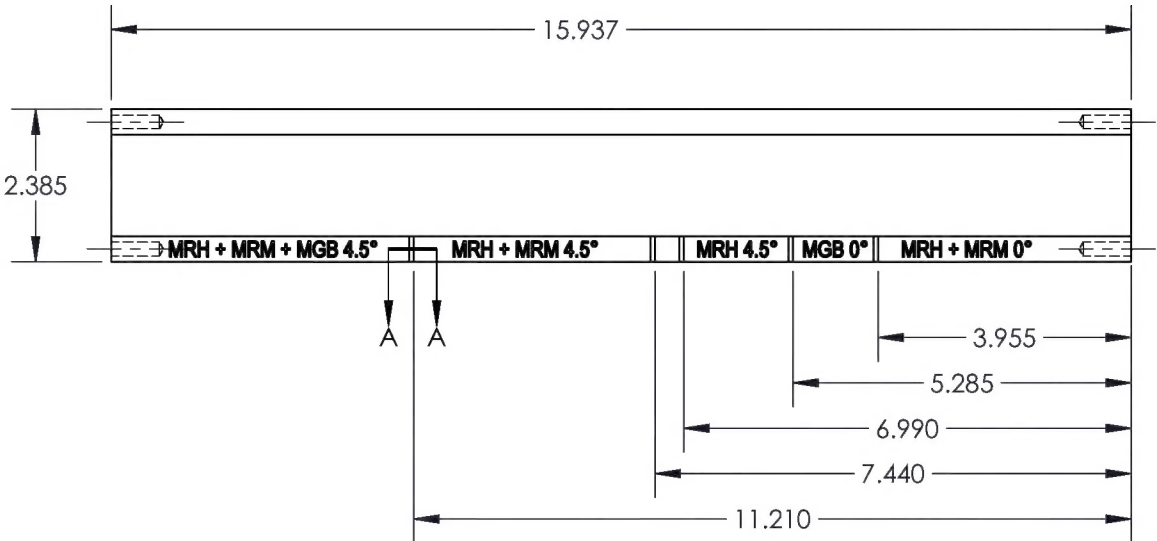
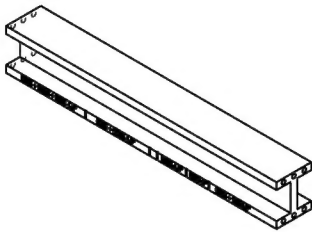
DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-3	REV 2
MAT'L FEAT TREAT FINISH ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:4	DATE 5/13/2016
SHEET 3 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A
SCALE 2 : 1
10 PLACES



MACHINE ENGRAVE
ALL TEXT AND MARKS
ARIAL 1/4 TEXT HT.

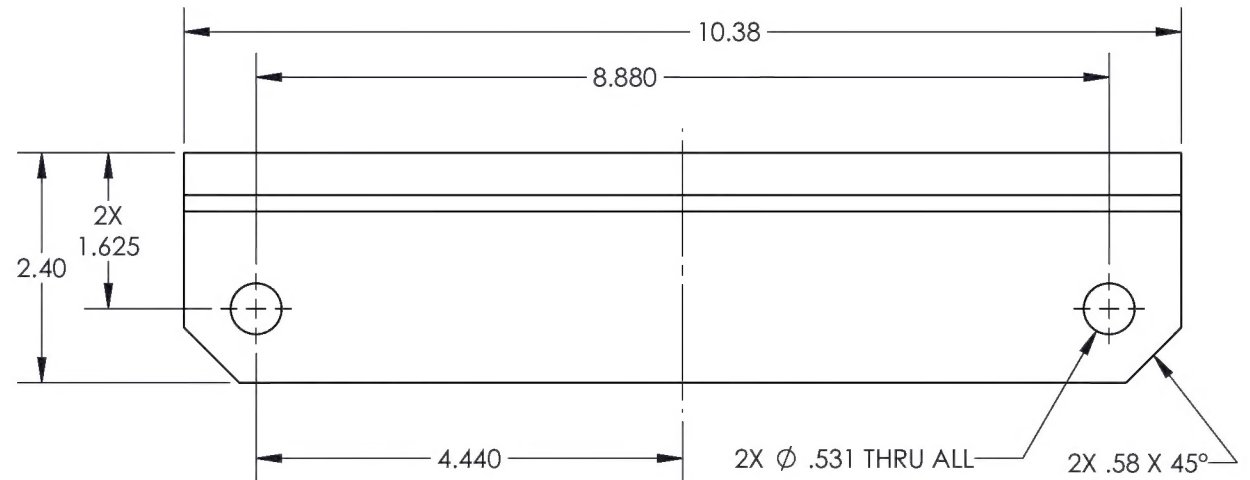
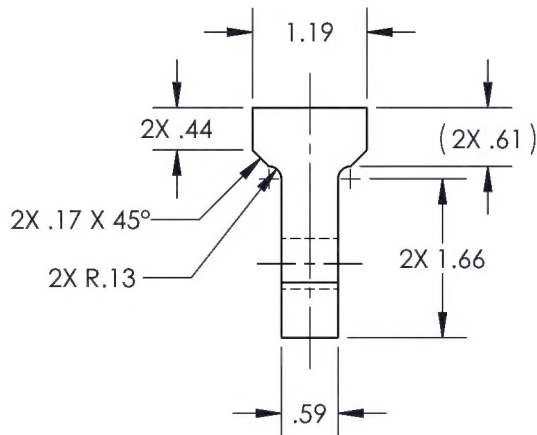
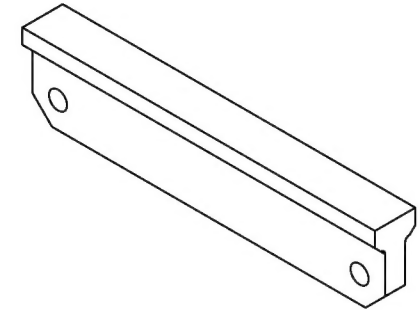
(5)

BEAM

DART AEROSPACE			
TITLE MAIN ROTOR HEAD SLING			
DWG NO. RBEM622U1005103-5			REV 2
MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH SEE -3		.XX ± .01 ANGLES ± 5°	
SPEC		.X ± .1 SURFACES = 125✓	
DRAWN BY: CLOUGH		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		H175	
SCALE 1:3		DATE 5/13/2016	SHEET 4 OF 31

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



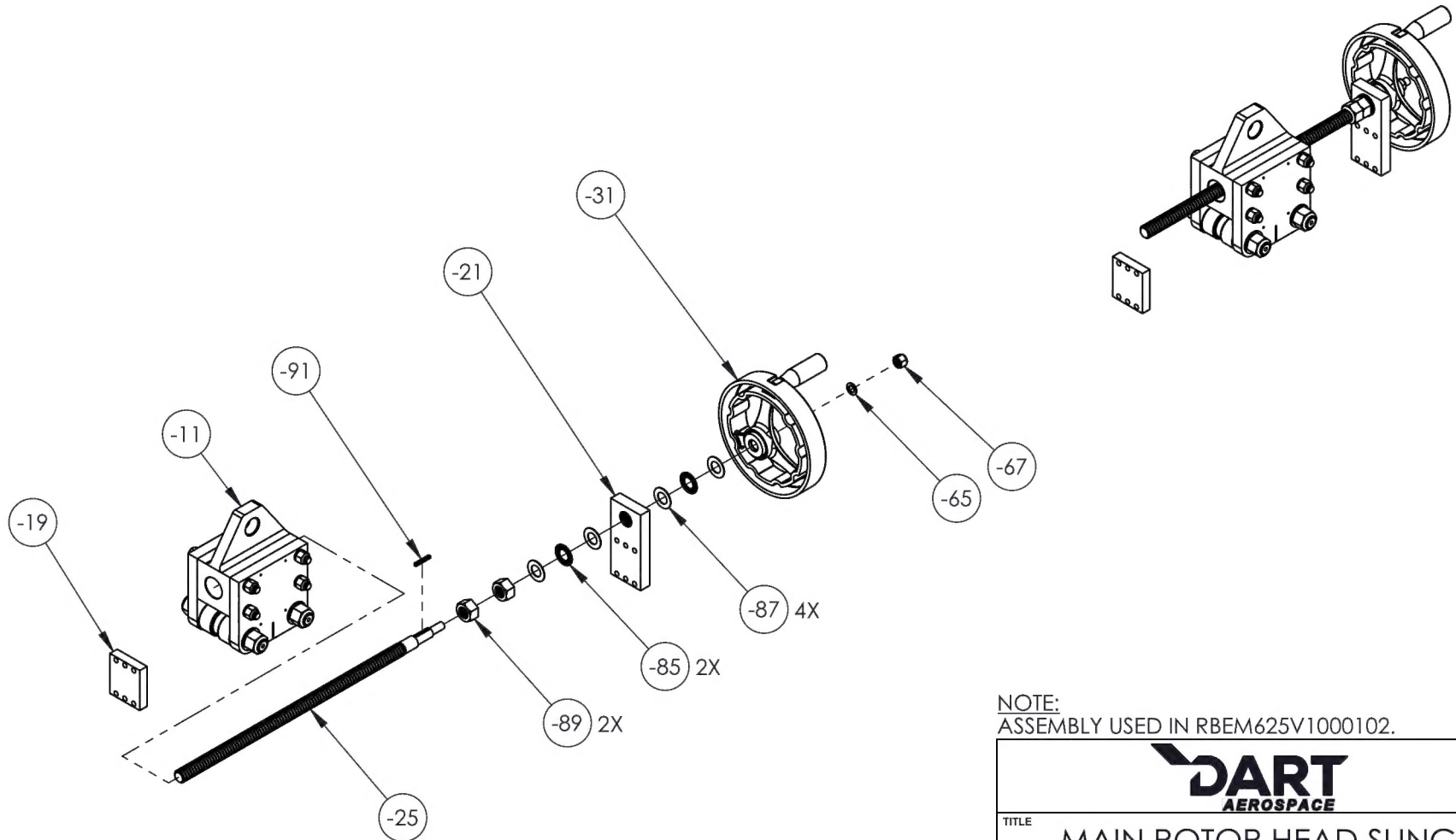
(-7)

BEAM MOUNT BAR

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-7	REV 2
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -3	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:2	DATE 5/13/2016
	SHEET 5 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-9 ADDED -65, -67, -85, -87, -89, -91 TO ASSEMBLY.	11/16/2016	DPD	JAG



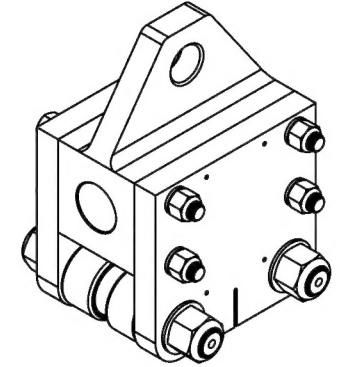
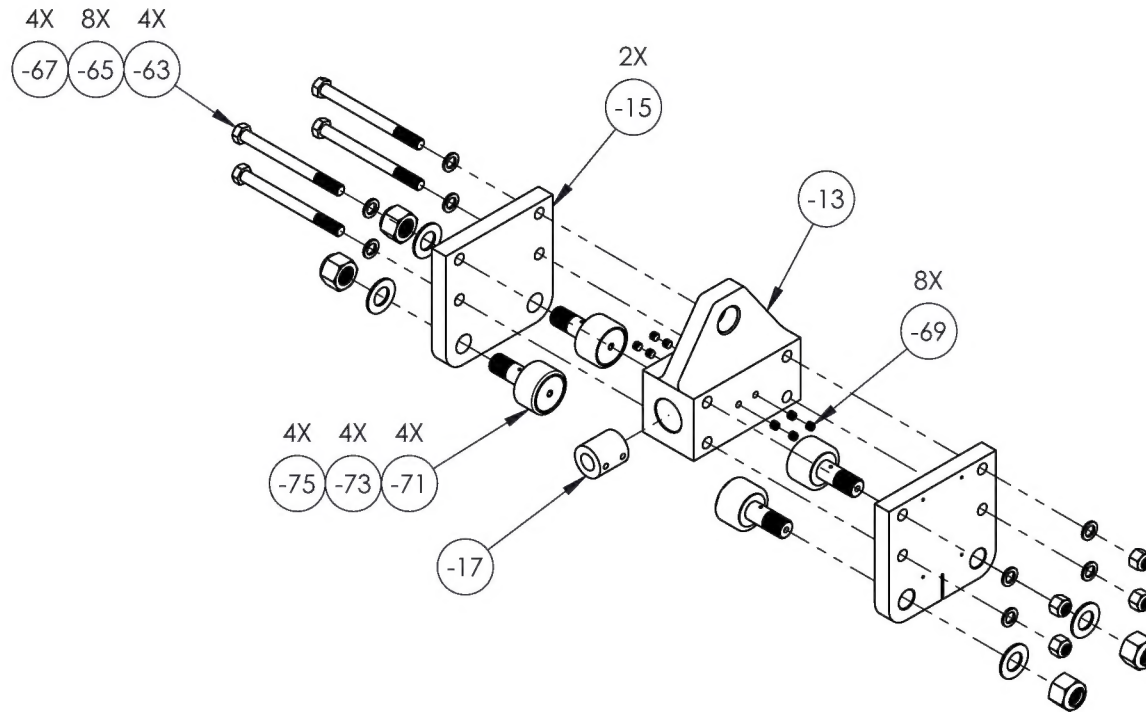
NOTE:
ASSEMBLY USED IN RBEM625V1000102.

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-9	REV 2
MAT'L REAR TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:8	DATE 5/13/2016
SHEET 6 OF 31	

SLING BLOCK/CRANK ASSY

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REVISIONS			
REV	ECR	DESCRIPTION	DATE



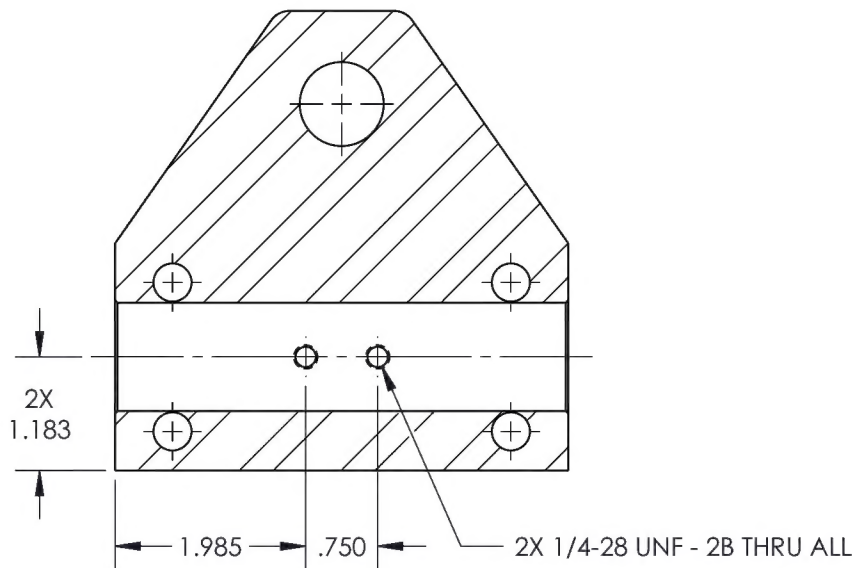
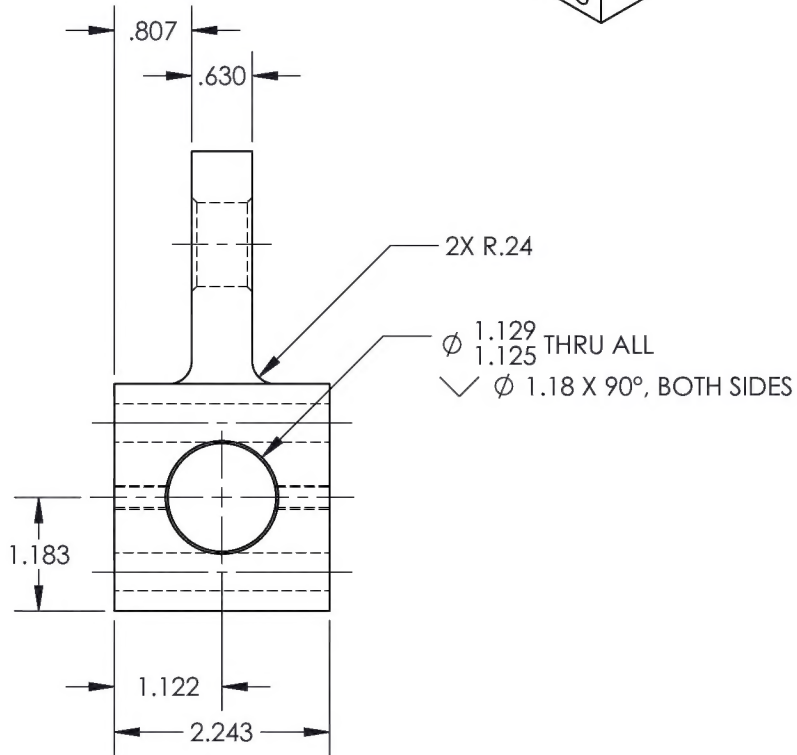
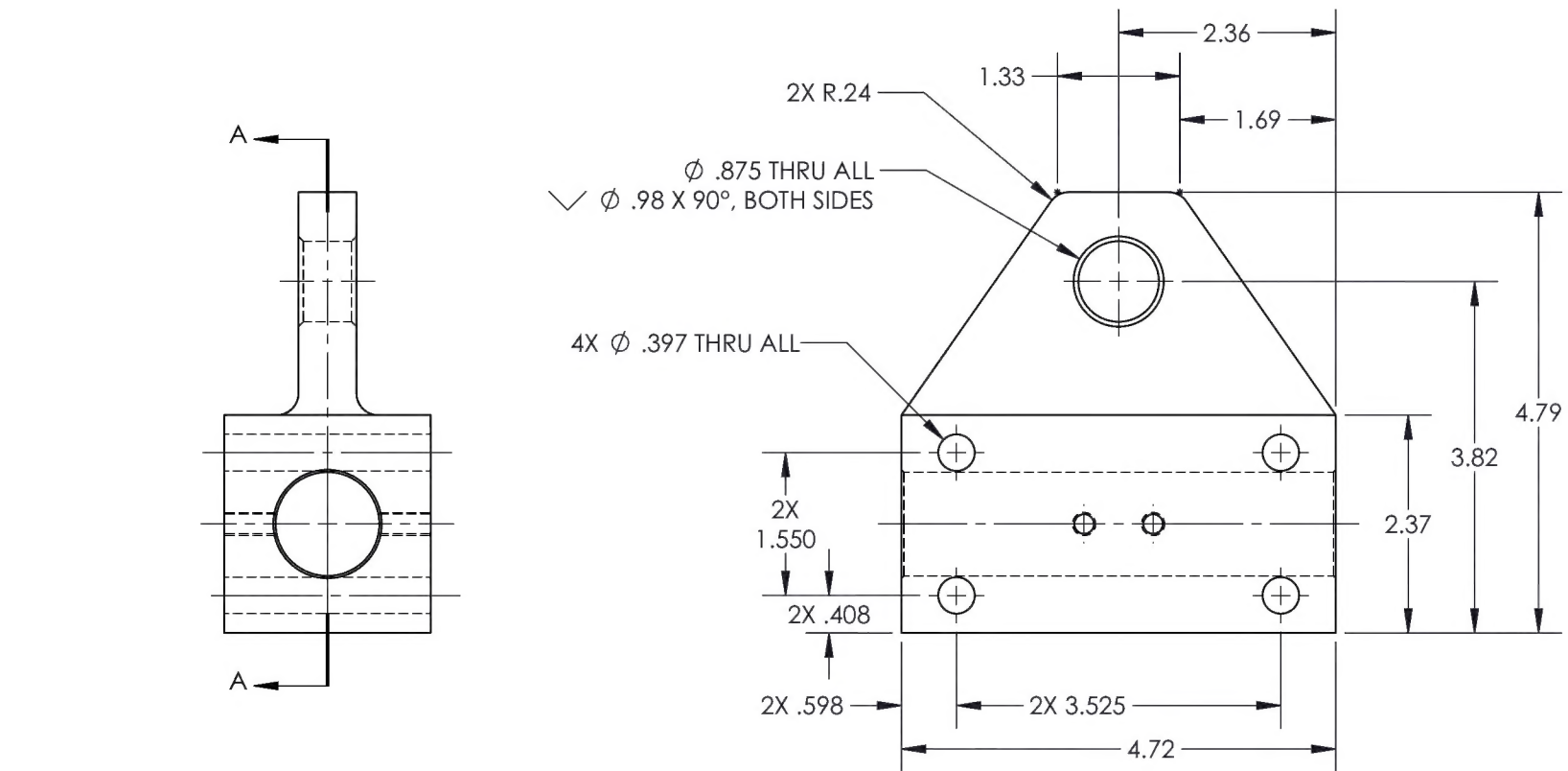
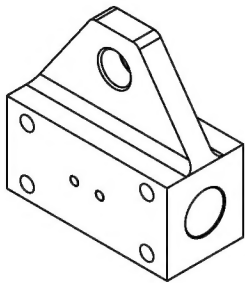
(11)

SLING BLOCK ASSEMBLY

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-11	REV 2
MAT'L REPT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:6	DATE 5/13/2016
SHEET 7 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-13 CH'D DIMS FROM Ø.755 THRU ALL ∇ Ø.80 X 90°, BOTH SIDES TO Ø.875 THRU ALL ∇ Ø.98 X 90° BOTH SIDES, FROM Ø1.126-1.129 THRU ALL ∇ Ø1.18 X 90°, BOTH SIDES TO Ø1.125-1.129 THRU ALL ∇ Ø1.18 X 90°, BOTH SIDES.	11/15/2016	DPD	JAG



SECTION A-A

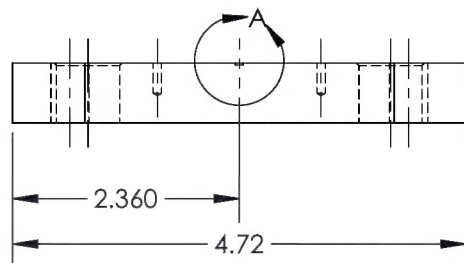
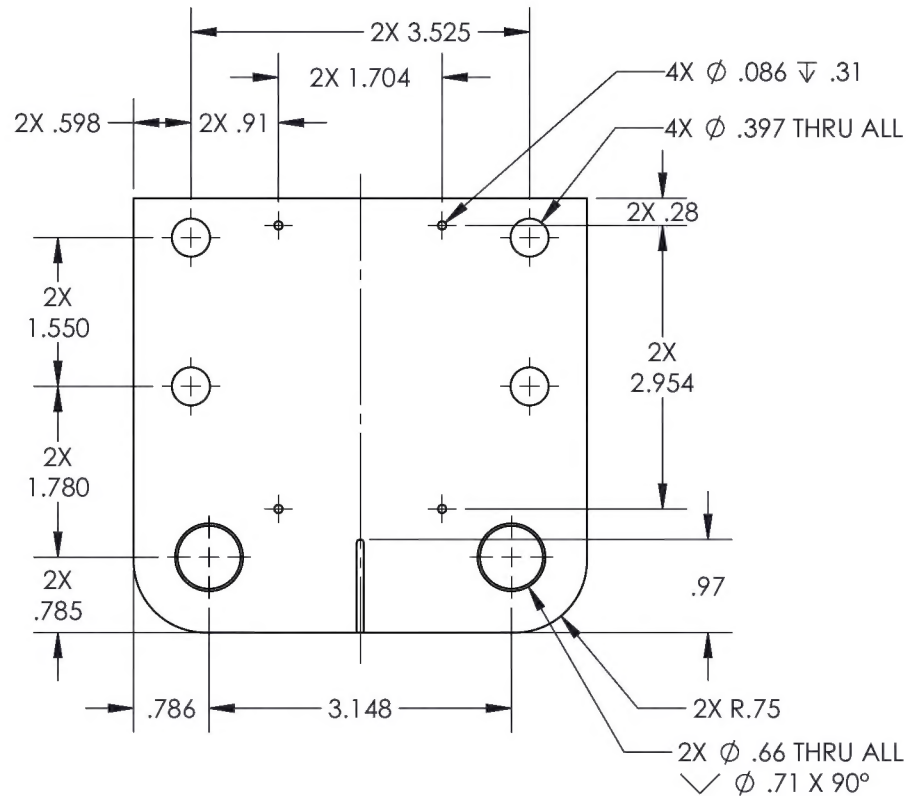
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SLING BLOCK

DART AEROSPACE			
TITLE MAIN ROTOR HEAD SLING			
DWG NO. RBEM622U1005103-13			REV 2
MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH ZINC PLATE		.XX ± .01 ANGLES ± 5°	
SPEC ASTM B633 TYPE I SC 2		.X ± .1 SURFACES = 125/	
DRAWN BY: CLOUGH		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		H175	
SCALE 1:2	DATE 5/13/2016	SHEET 8 OF 31	

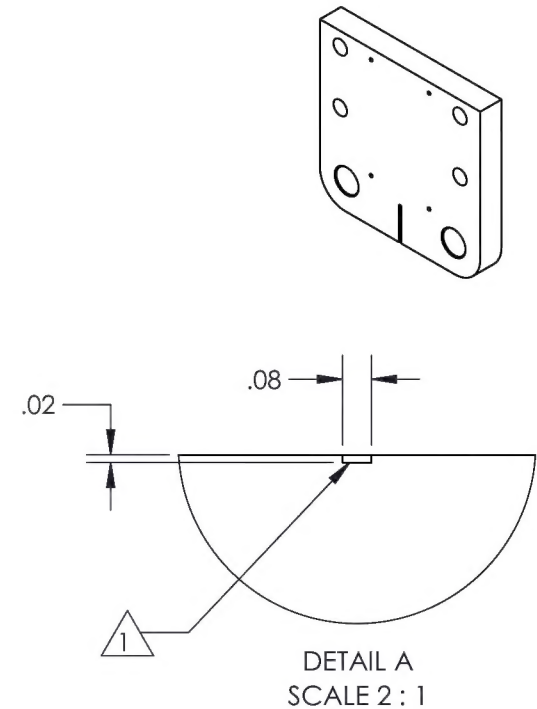
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2	16-0221	-15 CH'D DIM WAS 3.525 IS 2X 3.525. ADDED DIMS 2X .91, 2X 1.704, 2X .28, 2X 2.954, 4X Ø.086 ▽.31, .97, 2.360. DELETED DIM 2.323.	11/15/2016	DPD
				DPD



(-15)

SIDE PLATE



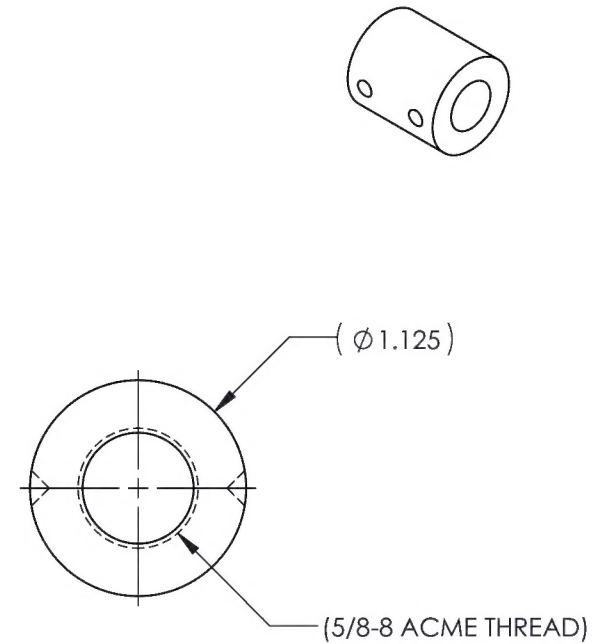
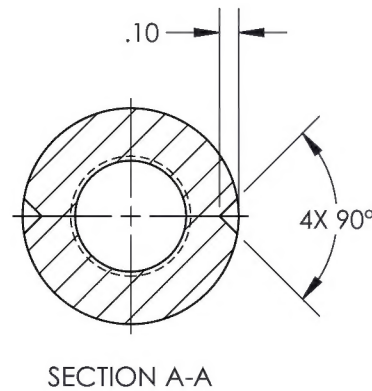
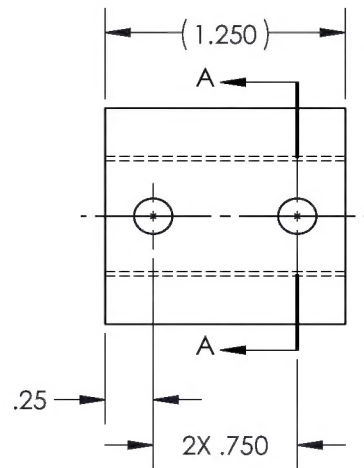
NOTE:

1 MACHINE ENGRAVE CENTERING MARK. FILL CENTERING MARK WITH BLACK PAINT.

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-15	REV 2
MAT'L 1018/1020 CR HEAT TREAT FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: MACKOVJAK	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 5/13/2016
SHEET 9 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

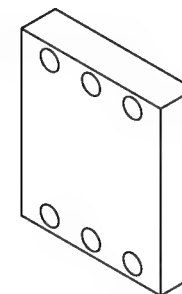
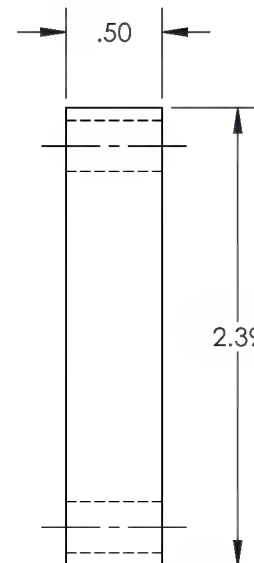
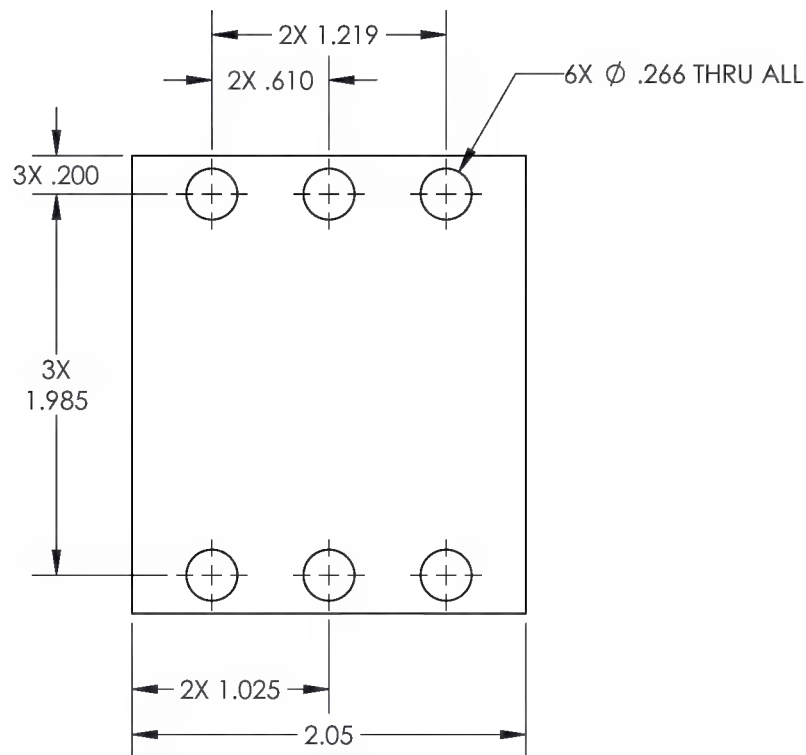


(-17)
ACME SLEEVE NUT

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-17	REV 2
MAT'L BRONZE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 5/13/2016
	SHEET 10 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-19 ADDED DIM 2X .610. CH'D MAT'L FROM 1018/1020 CR TO A36/1018/1020 HR.	11/15/2016	DPD	JAG

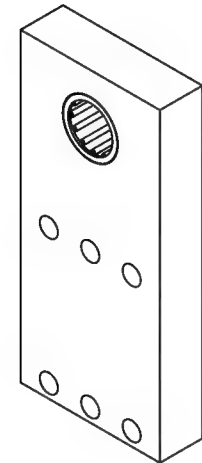
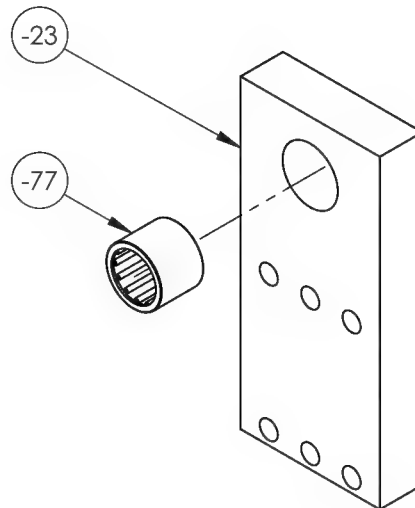


(-19)
END PLATE

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-19	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 5/13/2016
USED ON MODEL H175	
SHEET 11 OF 31	

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



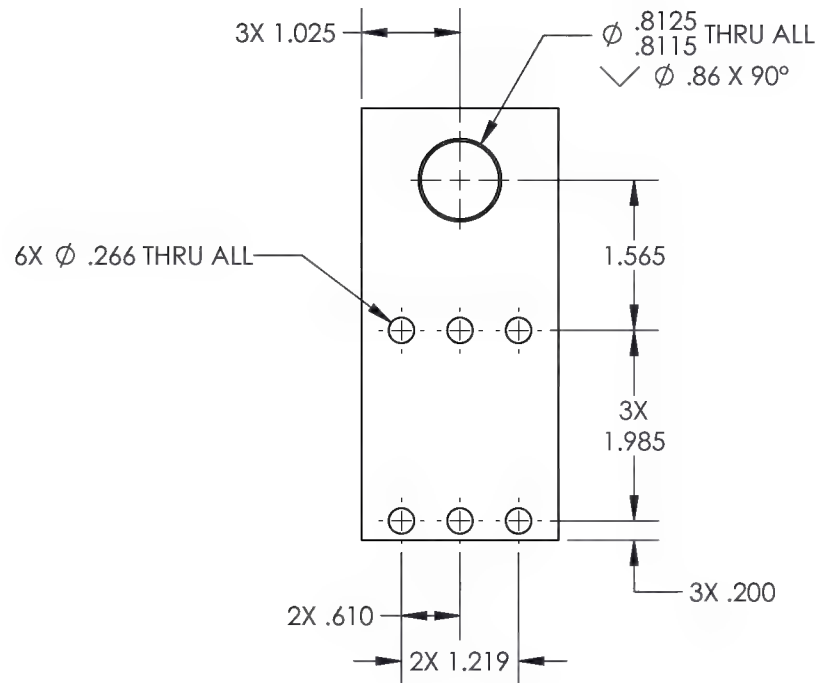
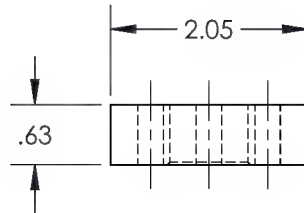
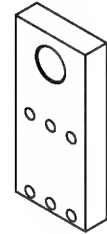
(-21)

CRANK END PLATE ASSEMBLY

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-21	REV 2
MAT'L FEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:2	DATE 5/13/2016
SHEET 12 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-23 CH'D MAT'L FROM 1018/1020 CR TO A36/1018/1020 HR.	11/15/2016	DPD	JAG



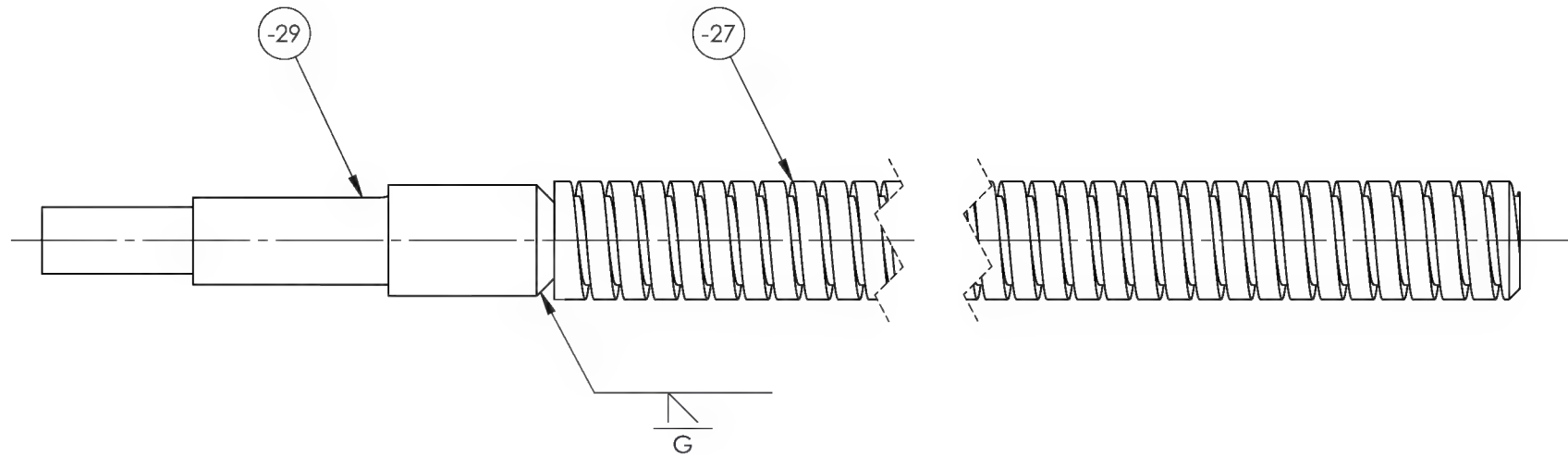
(-23)

CRANK END PLATE

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-23	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125° ✓
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 5/13/2016	USED ON MODEL
SHEET 13 OF 31	H175

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-25 DELETED -79 FROM ASSEMBLY. ADDED WELD SYMBOL. ADDED FINISH ZINC PLATE ASTM B633 TYPE 1 SC2.	11/15/2016	DPD	JAG

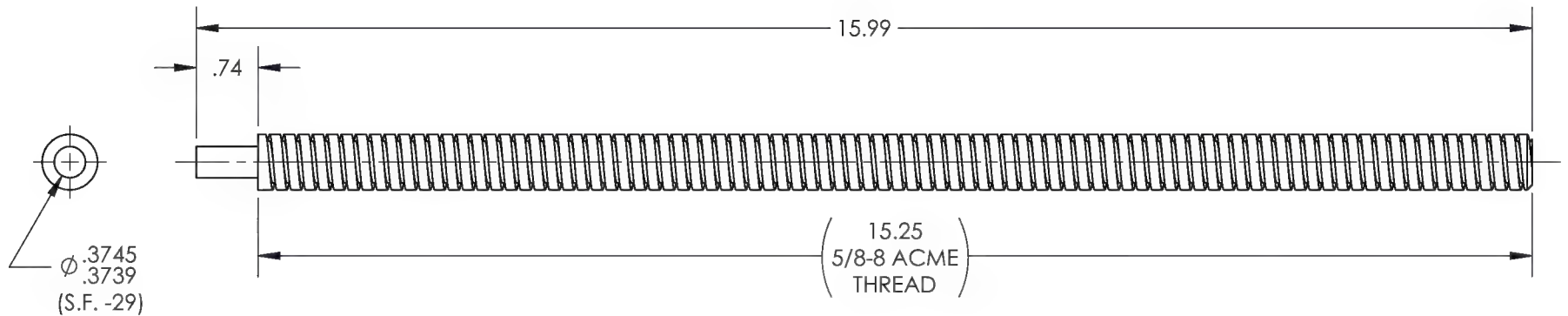
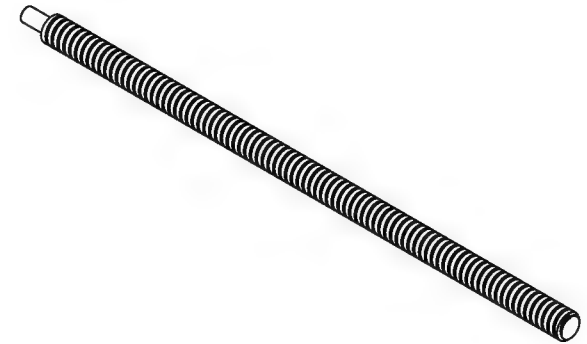


(25)
ACME ROD ASSEMBLY

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-25	REV 2
MAT'L ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE 1 SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:1	DATE 5/13/2016
SHEET 14 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-27 DELETED DIMS .365, Ø.1869-.1874 THRU ALL (P.F. -.79). CH'D FINISH FROM ZINC PLATE ASTM B633 TYPE I SC2 TO SEE -25.	11/15/2016	DPD	JAG



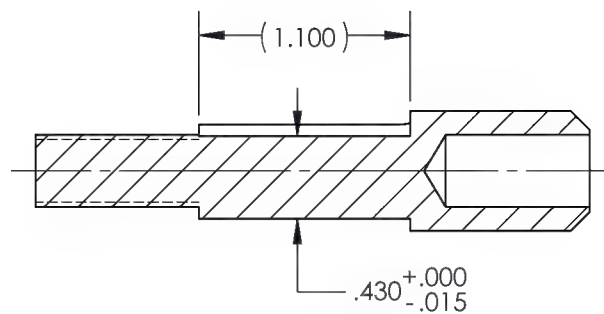
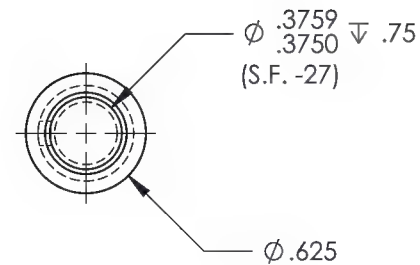
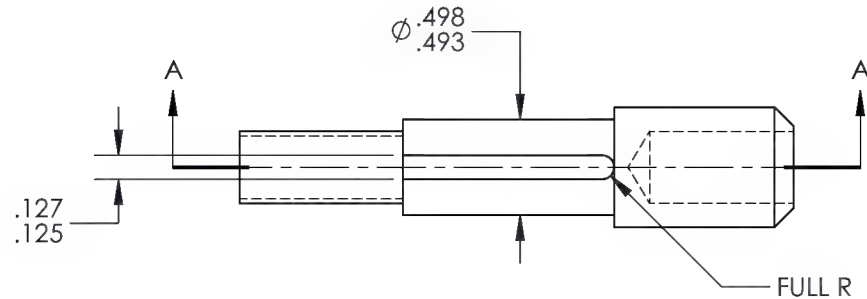
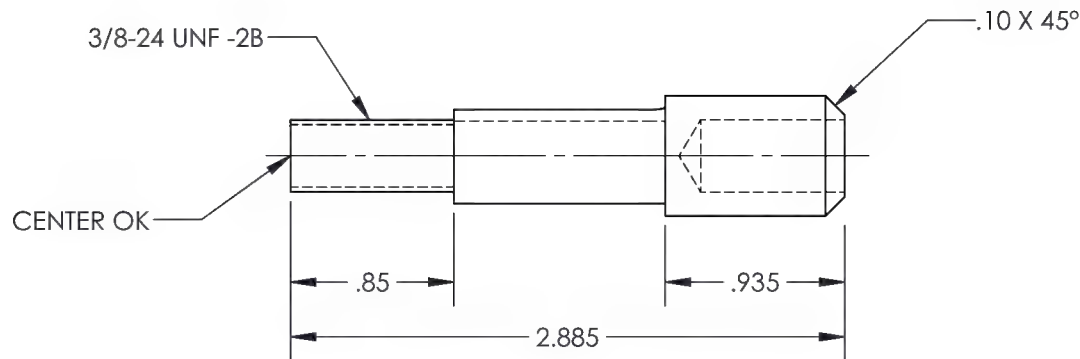
(-27)

ACME ROD

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-27	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -25	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC	.XX \pm .01 ANGLES \pm 5°
	.X \pm .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 5/13/2016
	SHEET 15 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-29 DELETED DIMS .375, Ø.1890-.1902 THRU ALL (S.F. -79). ADDED DIM .10 X 45°, CH'D MAT'L FROM 4140 Q&T/4142 Q&T TO 4140/4142. CH'D FINISH WAS ZINC PLATE ASTM B633 TYPE I SC2 IS SEE -25.	11/15/2016	DPD	JAG



SECTION A-A

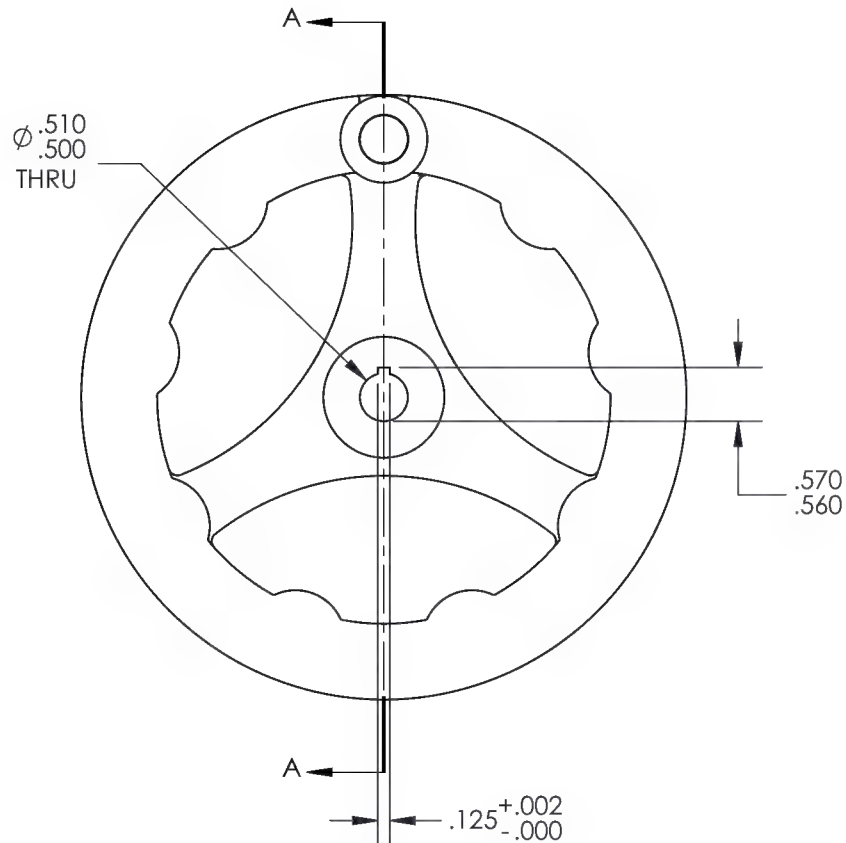
(-29)

ACME ATTACHMENT

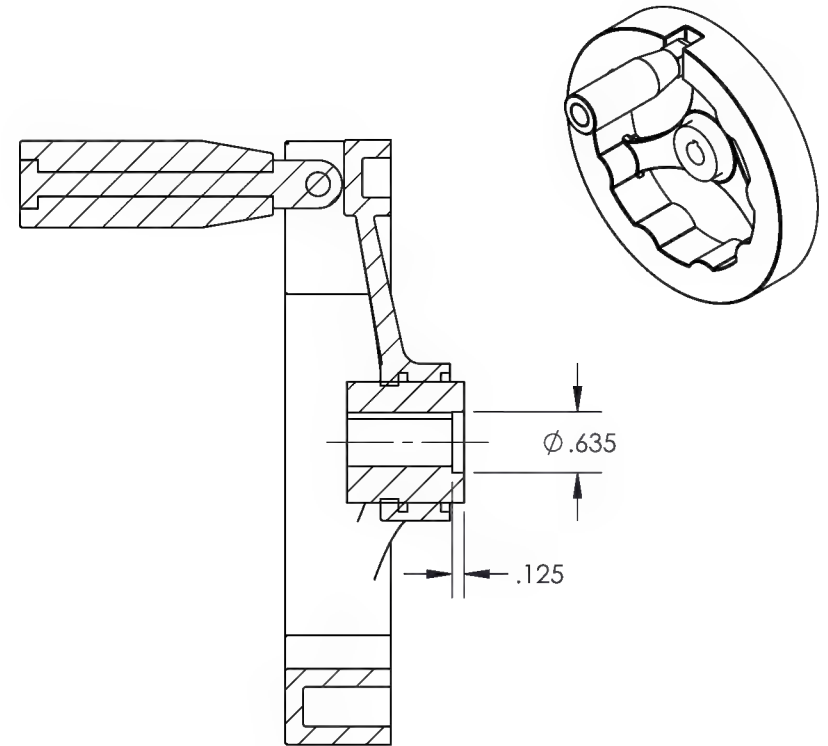
DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-29	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH SEE -25	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 5/13/2016
	SHEET 16 OF 31

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL



HIDDEN LINES REMOVED



SECTION A-A

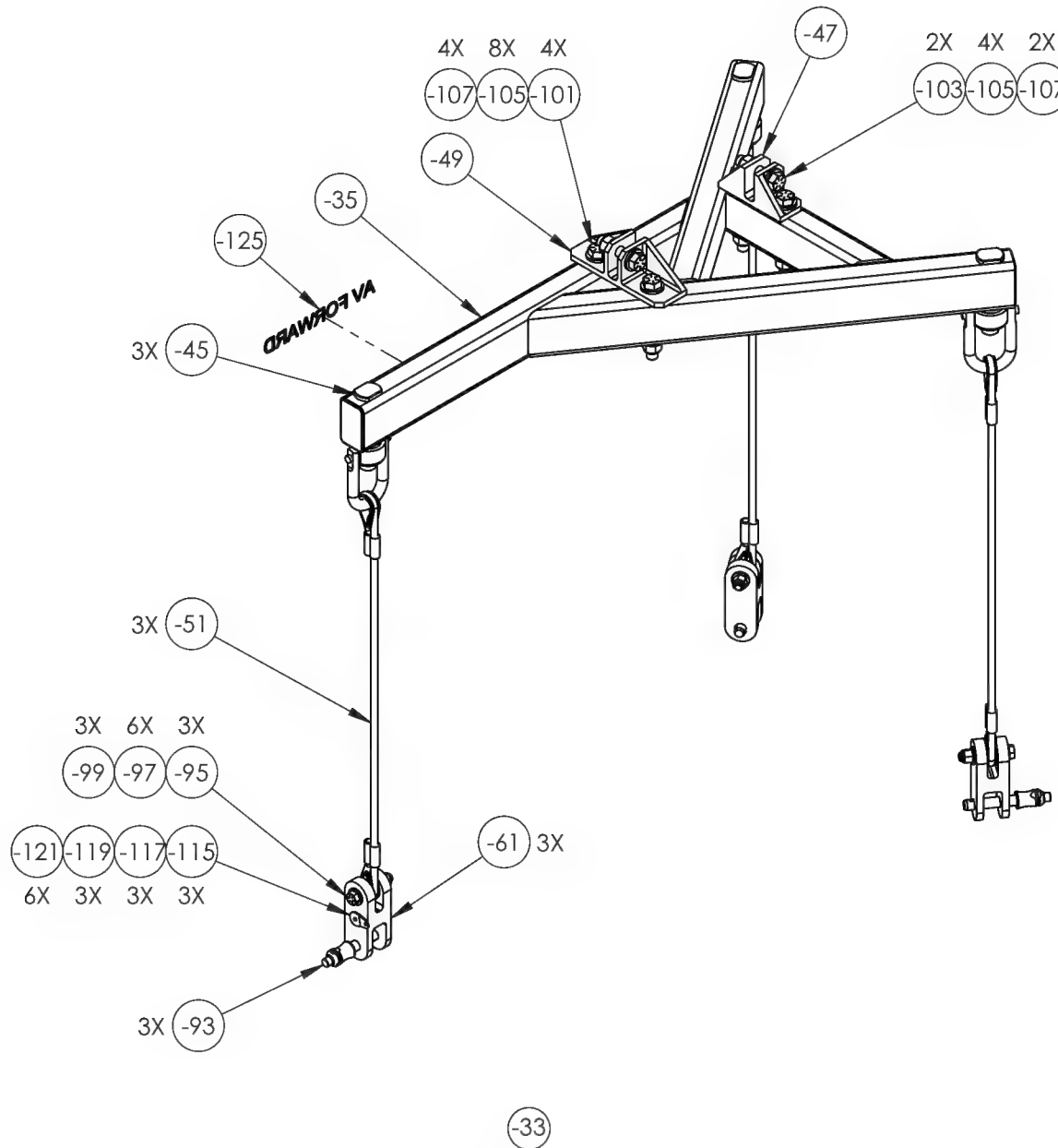
(-31)

HANDWHEEL

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-31	REV 2
MAT'L PLASTIC W/ STEEL HUB	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 5/13/2016
	SHEET 17 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-33 CORRECTED ORIENTATION OF -35. ADDED -125 DECAL TO ASSY.	1/4/2017	DPD	JAG

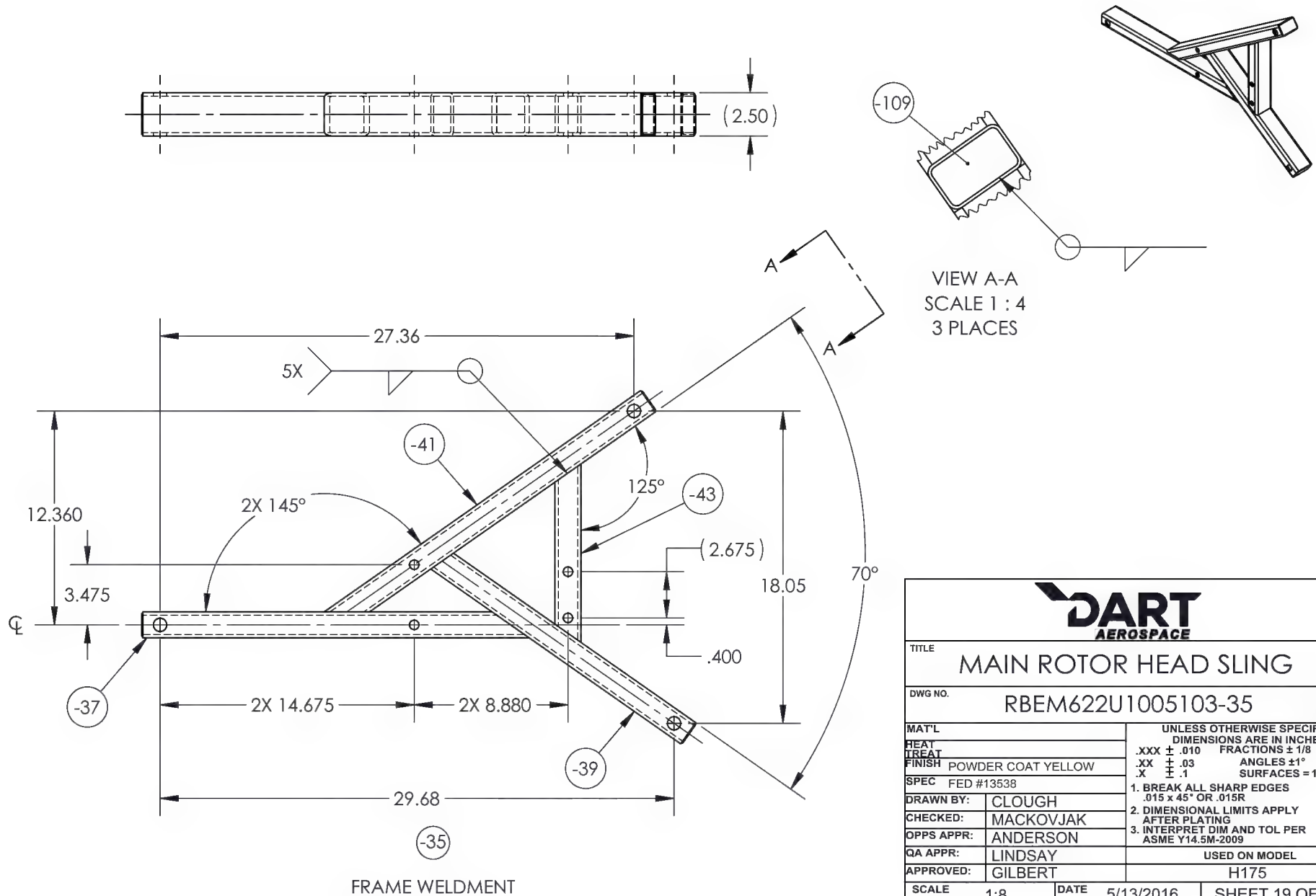


FRAME ASSEMBLY

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-33	REV 2
MAT'L FEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:8	DATE 5/13/2016
SHEET 18 OF 31	

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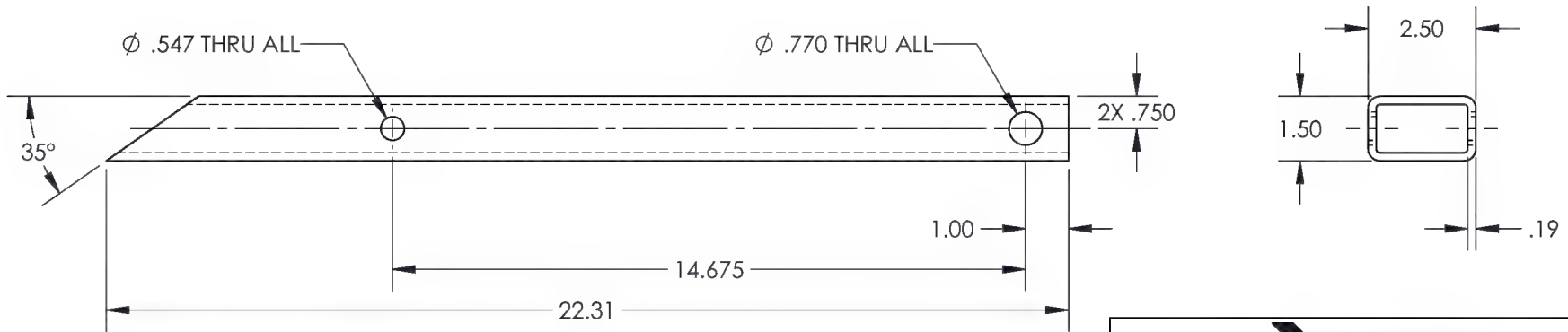
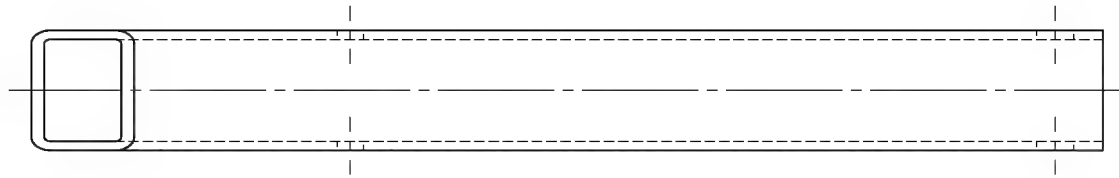
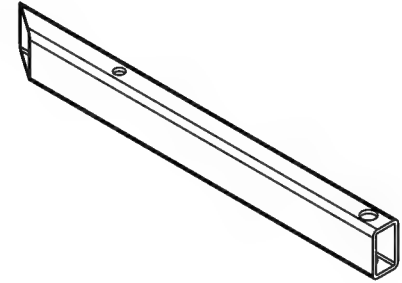
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-35 ADDED WELD SYMBOLS, CH'D DIM WAS 2.675 IS (2.675). ADDED -109 TO ASSY.	11/15/2016	DPD	JAG



DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-35	REV 2
MAT'L HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL H175
CHECKED: MACKOVJAK	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:8	DATE 5/13/2016
SHEET 19 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-37 CH'D MAT'L WAS A36/1018/1020 HR IS A500.	11/15/2016	DPD	JAG

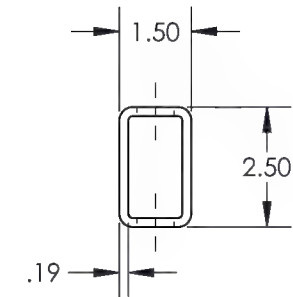
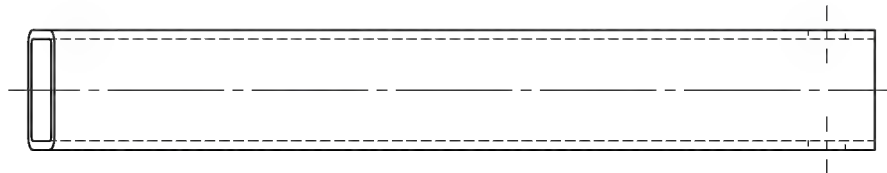
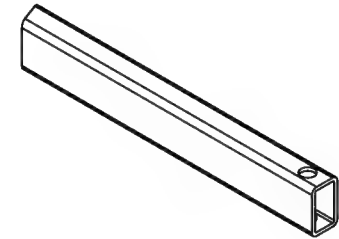
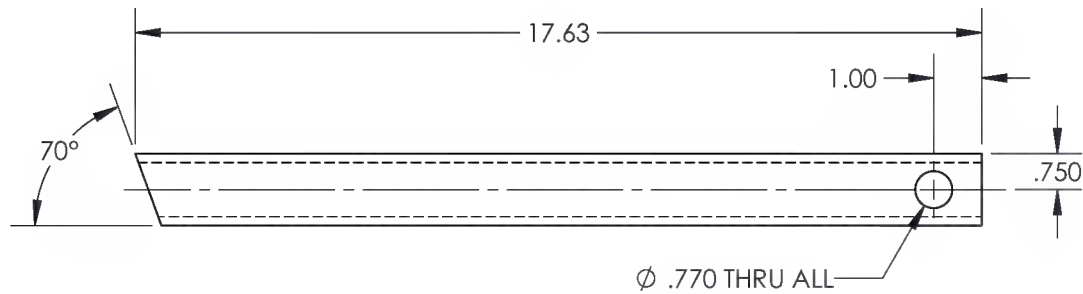


TITLE		MAIN ROTOR HEAD SLING	
DWG NO.		RBEM622U1005103-37	
REV		2	
MAT'L A500		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -35		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: CLOUGH		.X ± .1 SURFACES = 125°	
CHECKED: MACKOVJAK		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:4		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 5/13/2016		USED ON MODEL	
SHEET 20 OF 31		H175	

(-37)
TUBE A

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-39 CH'D MAT'L FROM A36/1018/1020 HR TO A500.	11/15/2016	DPD	JAG



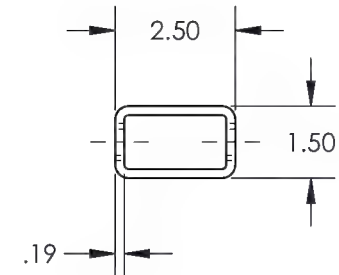
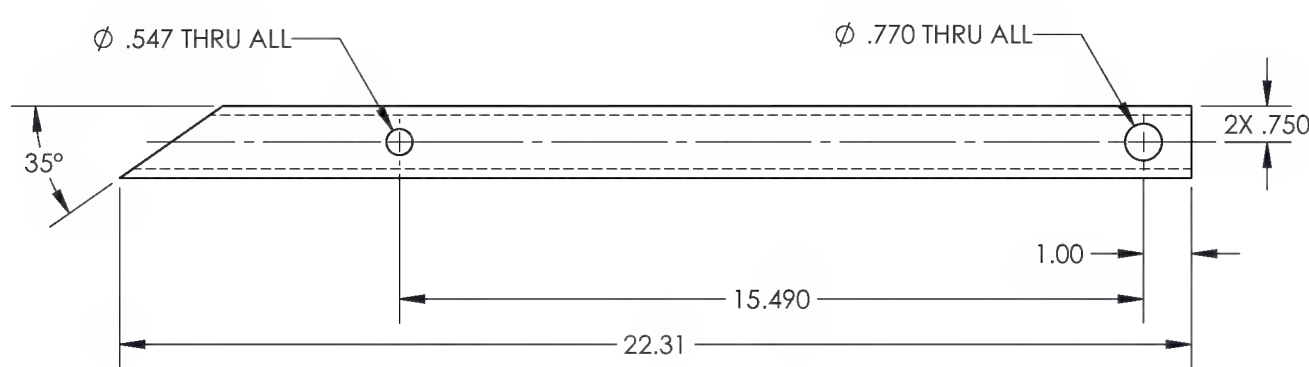
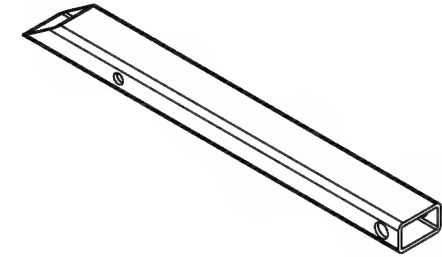
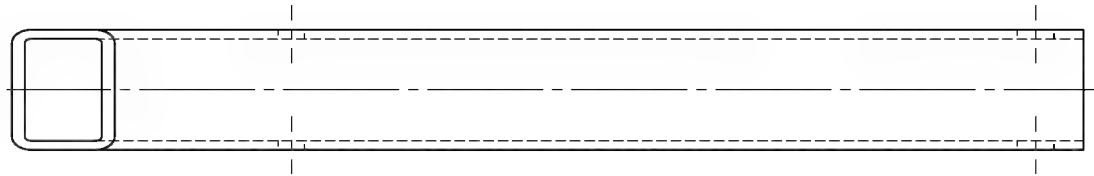
(-39)

TUBE B

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-39	REV 2
MAT'L A500	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -35	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:4	DATE 5/13/2016
	SHEET 21 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-41 CH'D MAT'L FROM A36/1018/1020 HR TO A500.	11/15/2016	DPD	JAG

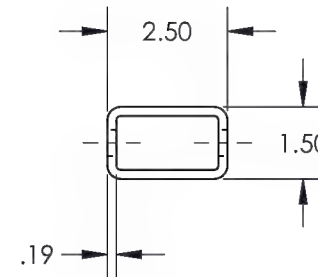
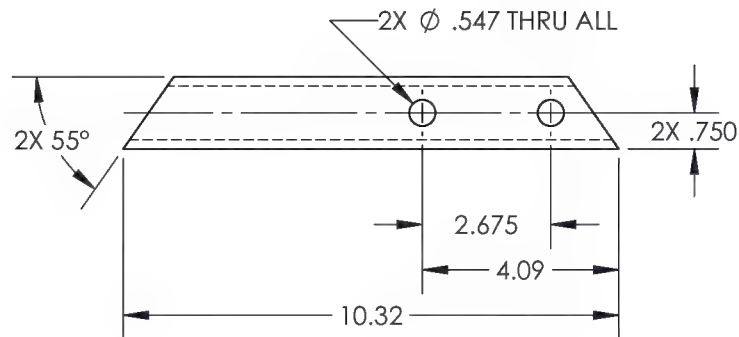
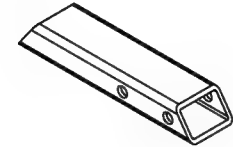
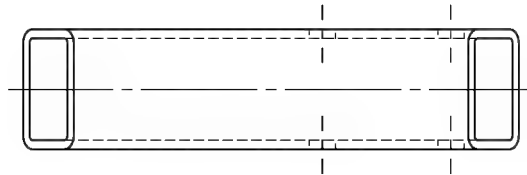


(-41)
TUBE C

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-41	REV 2
MAT'L A500	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -35	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:4	DATE 5/13/2016
SHEET 22 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-43 CH'D MAT'L WAS A36/1018/1020 HR IS A500.	11/15/2016	DPD	JAG



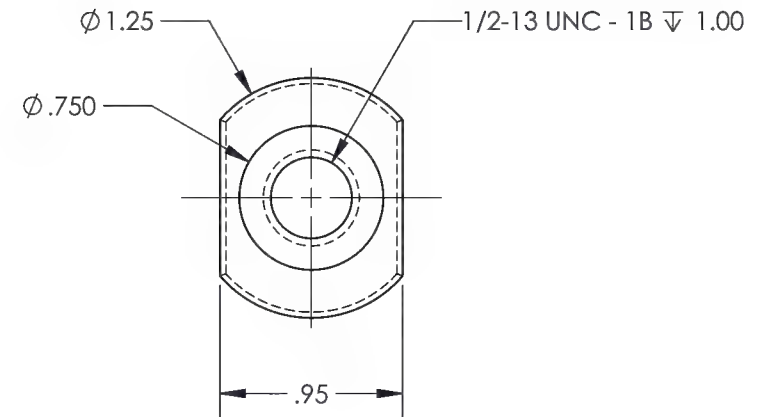
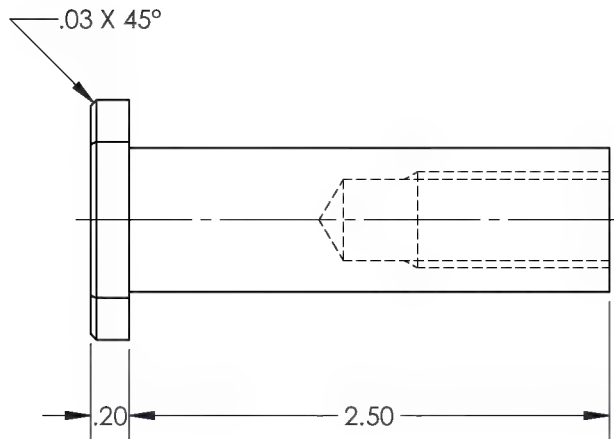
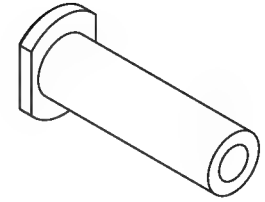
(-43)

TUBE D

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-43	REV 2
MAT'L A500	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -35	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:4	USED ON MODEL
DATE 5/13/2016	H175
SHEET 23 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL



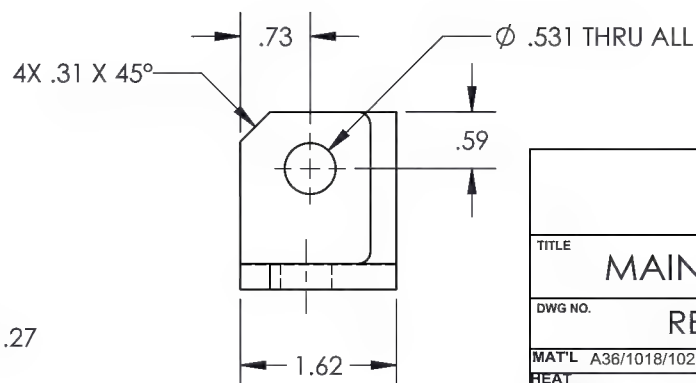
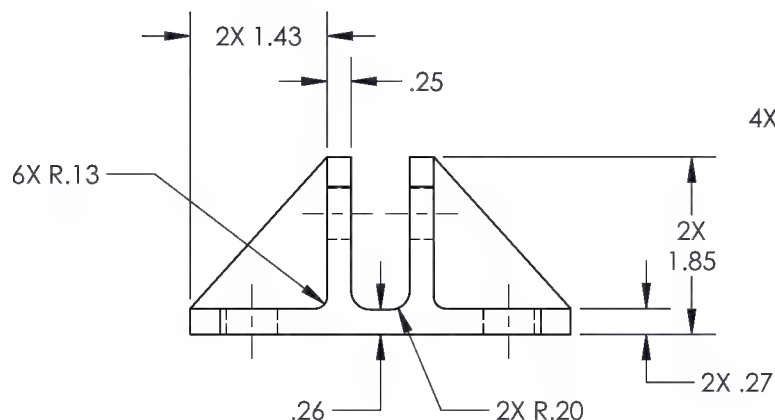
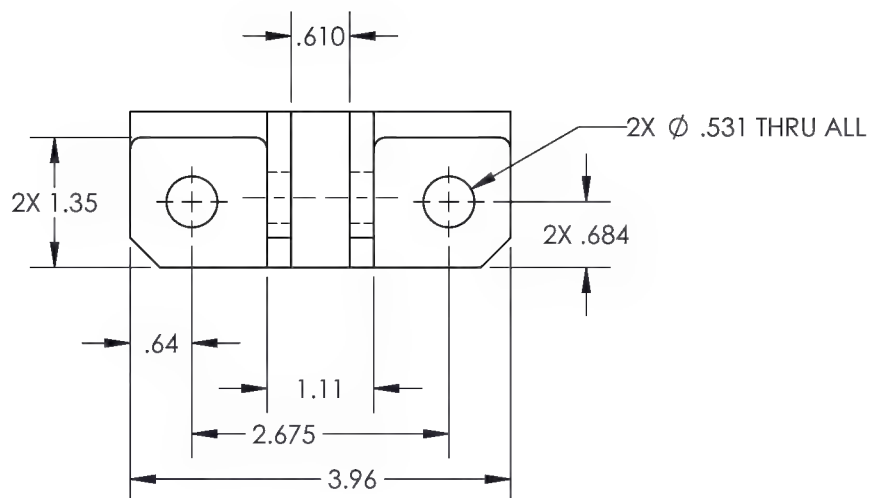
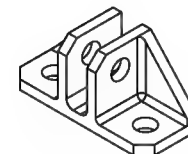
(-45)

BUSHING

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-45	REV 2
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± .5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125°
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 5/13/2016	USED ON MODEL
SHEET 24 OF 31	H175

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



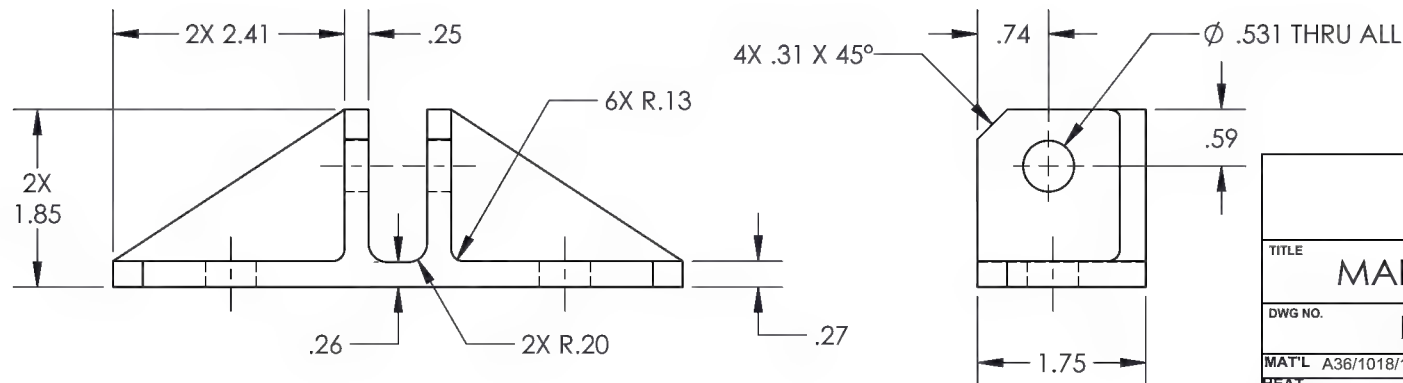
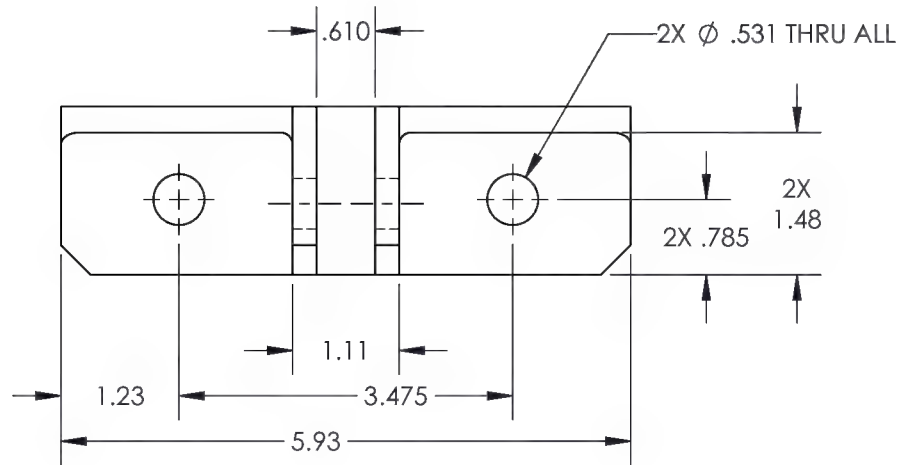
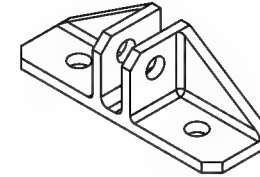
(-47)

SMALL MOUNT BRACKET

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-47	REV 2
MAT'L A36/1018/1020 HR HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL H175
CHECKED: MACKOVJAK	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 5/13/2016
SHEET 25 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



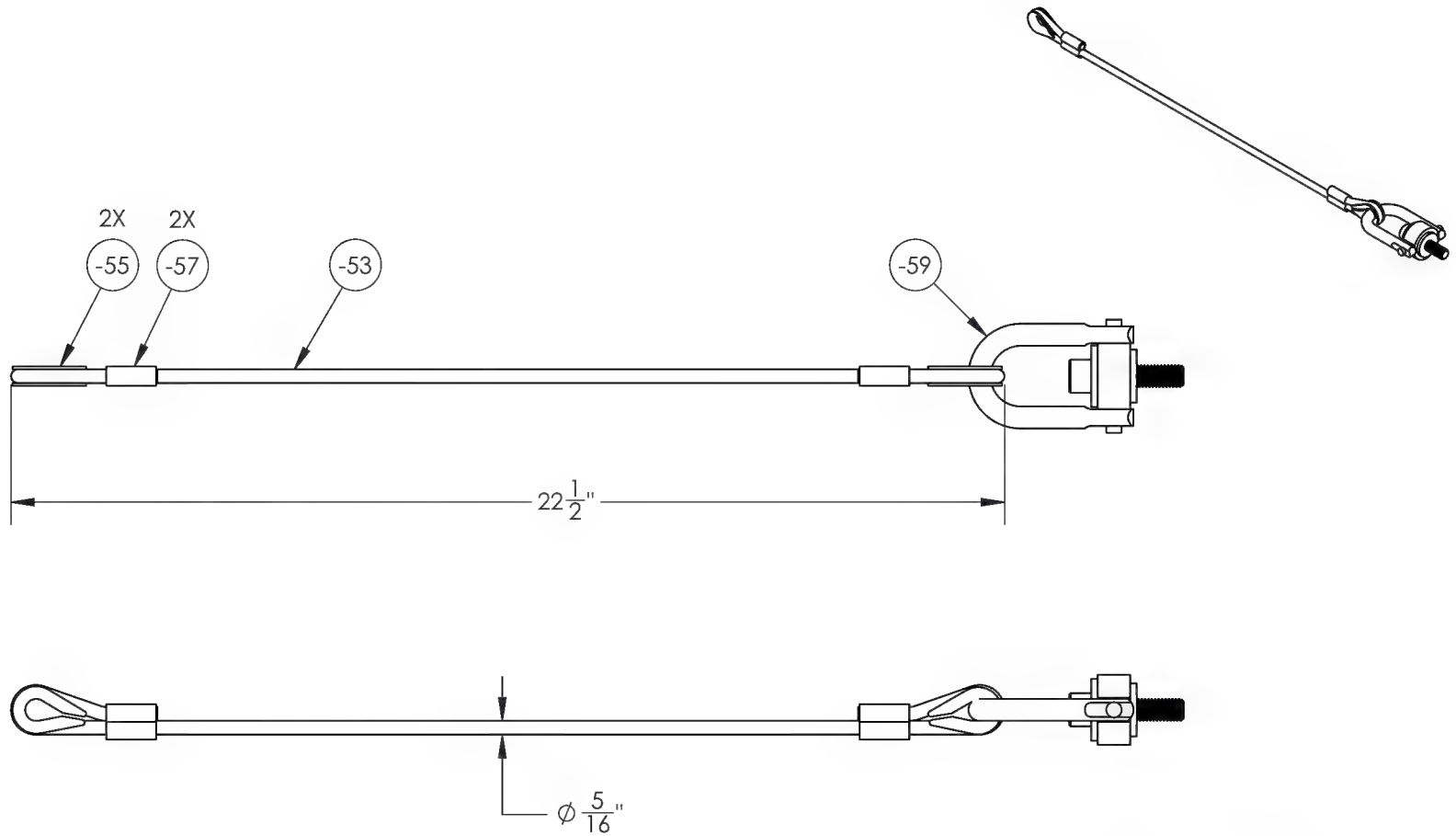
(-49)

LONG MOUNT BRACKET

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-49	REV 2
MAT'L A36/1018/1020 HR HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: MACKOVJAK	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 5/13/2016
SHEET 26 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL



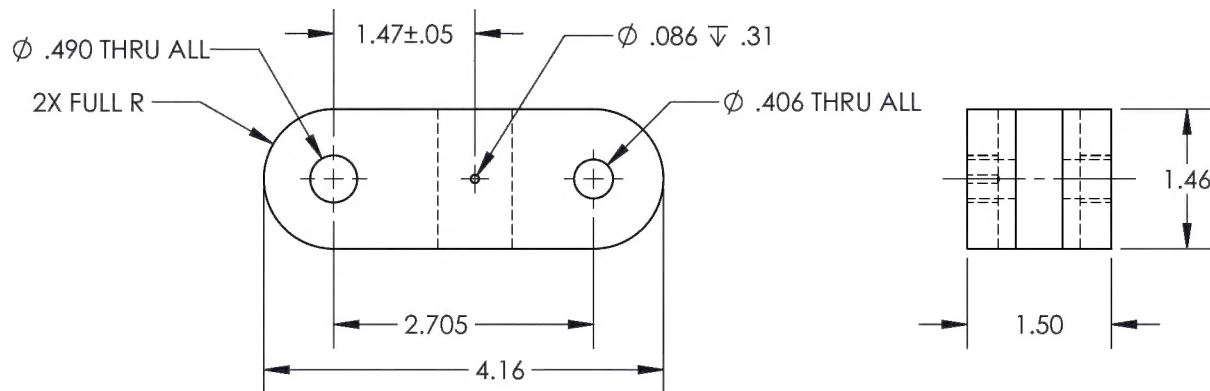
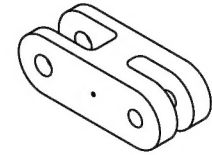
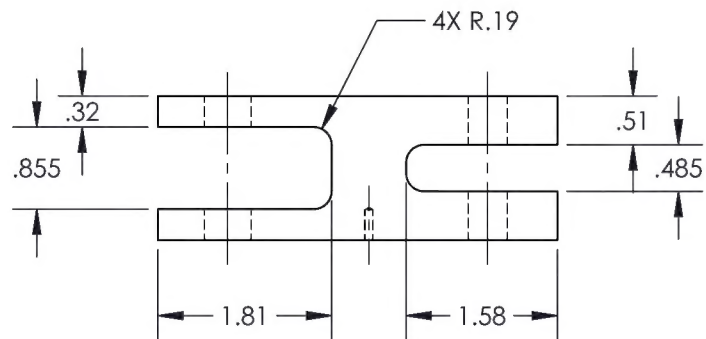
(51)

CABLE ASSEMBLY

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-51	REV 2
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:4	DATE 5/13/2016
SHEET 27 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-61 CH'D MAT'L WAS 1018/1020 CR IS 4140/4142. ADDED DIM 1.47±.05. CH'D DIMS WAS .508 IS .51, WAS Ø.095-.098 ∇ .15 IS Ø.086 ∇ .31.	11/15/2016	DPD	JAG

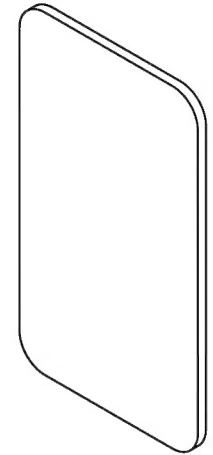
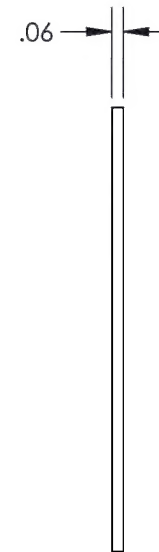
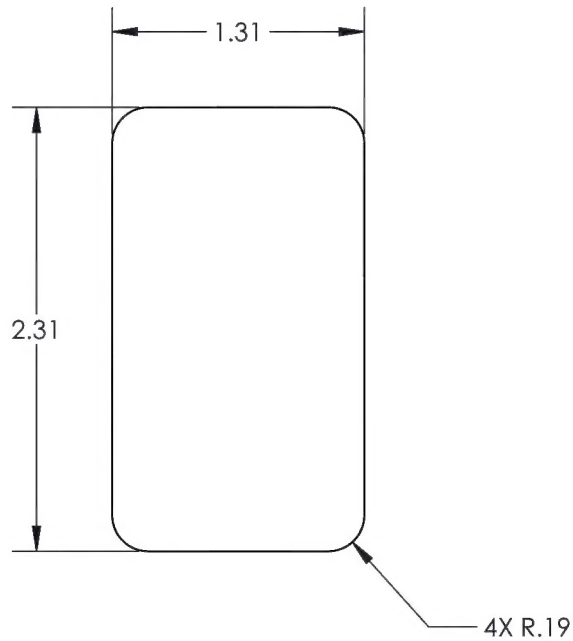


(-61)
LINK

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-61	REV 2
MAT'L 4140/4142 HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH CHECKED: MACKOVJAK OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL H175	
SCALE 1:2	DATE 5/13/2016
SHEET 28 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-109 ADDED DRAWING. CH'D MAT'L WAS POLYETHYLENE IS A36/1018/1020 HR. WAS B/O IS MANUFACTURED.	1/3/2017	DPD	JAG



-109
 TUBE CAP

TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-109	REV 2
MAT'L A36/1018/1020 HR TREAT FINISH SEE -35 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: CLOUGH CHECKED: MACKOVJAK OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	USED ON MODEL H175
SCALE 1:1	DATE 5/13/2016
SHEET 29 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0221	-125 ADDED TO BOM QTY: 1. ADDED DRAWING.	1/4/2017	DPD	JAG

AV FORWARD

AV FORWARD

3/4"

7 1/16"

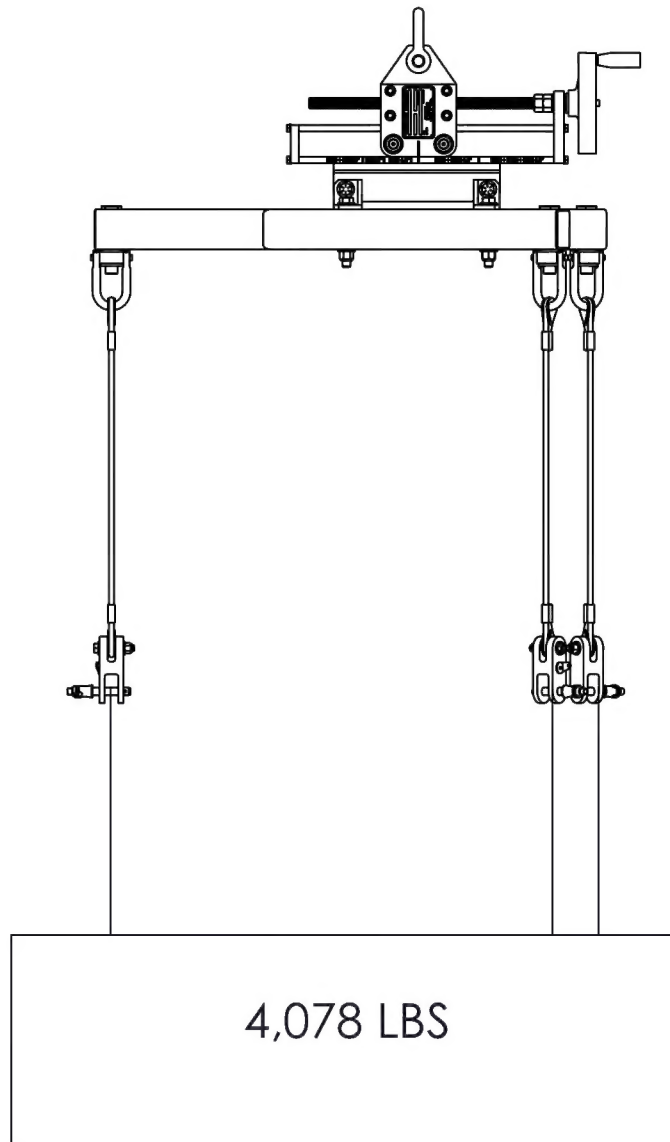
ARIAL FONT

-125

DECAL

DART AEROSPACE	
TITLE MAIN ROTOR HEAD SLING	
DWG NO. RBEM622U1005103-125	REV 2
MAT'L BLACK VINYL	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
SCALE 1:1	ASME Y14.5M-2009
DATE 1/4/2017	USED ON MODEL
SHEET 30 OF 31	H175

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INSPECTION & TESTING PROCEDURES FOR THE RBEM622U105103, MAIN ROTOR HEAD SLING.

- INSPECT THIS ASSEMBLY BEFORE EACH USE.
- REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, ATTACH SLING ASSEMBLY TO AN OVERHEAD LIFTING DEVICE.
2. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF 4,078 LBS. ADJUST THE POSITION OF THE SLING IF NECESSARY TO ENSURE THAT THE SLING REMAINS LEVEL.
3. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION.
4. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.

INSPECTOR: _____

TESTER: _____

S/N: _____

DATE: _____



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e-mail: sales@dartaero.com
dartaerospace.com

TITLE MAIN ROTOR HEAD SLING			
DWG NO. RBEM622U1005103	REV 2	CUSTOMER 1 OF 1	
SCALE 1:12	DATE 5/13/2016	SHEET	31 OF 31